State of Montana
Department of Environmental Quality
Helena, Montana 59620

AIR QUALITY OPERATING PERMIT NUMBER OP2619-01

Administrative Amendment Received: **October 10, 2003**
Application Deemed Administratively Complete: **October 14, 2003**
Application Deemed Technically Complete: **October 15, 2003**
AFS Number: **030-111-0011A**

Date of Decision: **October 30, 2003**
Effective Date: **December 2, 2003**
Expiration Date: **July 9, 2007**

In accordance with the Montana Code Annotated sections 75-2-217 and 218, and the Administrative Rules of Montana (ARM) Title 17, Chapter 8, Subchapter 12, Operating Permit Program, ARM 17.8.1201, *et seq*.,

ConocoPhillips Company
Billings Refinery
NW¼ Section 2, Township 1 South, Range 26 East, Yellowstone County, MT
P.O. Box 30198
401 South 23rd Street
Billings, MT 59107-0198

hereinafter, referred to as ConocoPhillips, is authorized to operate a stationary source of air contaminants consisting of the emission units described in this permit. Until this permit expires or is modified or revoked, ConocoPhillips is allowed to discharge air pollutants in accordance with the conditions of this permit. All conditions in this permit are federally and state enforceable unless otherwise specified. Requirements, which are state only enforceable, are identified as such in the permit. A copy of this permit must be kept on site at the above named facility.

Issued by the Department of Environmental Quality

_____ _____
Signature Date

Permit Issuance and Appeal Process: In accordance with ARM 17.8.1210(j), the Department of Environmental Quality's (Department) decision regarding issuance of an operating permit is not effective until 30 days have elapsed from the date of the decision issued October 30, 2003. The decision may be appealed to the Board of Environmental Review (Board) by filing a request for a hearing within 30 days after the date of decision. If no appealed is filed then the Department will send notification and a final permit cover page to be attached to this document stating that the permit is final. Questions regarding the final issuance date and status of appeals should be directed to the Department at (406) 444-3490.

Terms not otherwise defined in this permit or in the Definitions and Abbreviations Appendix of this permit have the meaning assigned to them in the referenced regulations.

SECTION I. GENERAL INFORMATION

The following general information is provided pursuant to ARM 17.8.1210(1).

Company Name: **ConocoPhillips, Company, Billings Refinery**

Mailing Address: **P.O. Box 30198, 401 South 23rd Street**

City: **Billings** State: **Montana** Zip: **59107-0198**

Plant Location: **NW¼ Section 2, Township 1 South, Range 26 East, Yellowstone County**

Responsible Official: **Jay Churchill** Phone: **(406) 255-2551**

Facility Contact Person: **Randall Richert** Phone: **(406) 255-2580**

Primary SIC Code: **2911**

Nature of Business: **Petroleum Refining**

Description of Process: **The refining process distills crude oil using heat. This distillation separates the crude oil into its component parts. The refiner then cracks some of the heavier molecules by applying heat in the presence of a catalyst to make the reaction take place. These raw products are then treated in several ways to take out impurities. Finally, the proper liquids and additives are blended to create the desired product. The ConocoPhillips Billings Refinery also includes the Jupiter Sulfur Recovery Facility. The recovery facility utilizes sulfur from the refining process to produce fertilizer.**

SECTION II. SUMMARY OF EMISSION UNITS

The emission units regulated by this permit are the following (ARM 17.8.1211):

Emission Unit ID	Description	Pollution Control Device/Practice
EU001	Boiler House Stack: - Boiler #B-1, Boiler #B-2, - Boiler #B-5, and Boiler #B-6.	None
EU002	FCCU Stack - FCCU Regenerator	None
EU003	24 Fuel Gas Combustion Units - H-1, H-2, H-4, H-5, H-10, H-11, H-12, H-13, H-14, H-15, H-16, H-17, H-18, H-19, H-20, H-21, H-22, H-23, H-24, H-3901, H-8401, H-8402, Hydrogen Plant Heater (H-9401), and PB Merox Unit.	None
EU004	PMA Process Heater (H-3201) - PMA Process Heater, and Storage Tank Vent	None
EU005	Refinery Flare - Emergency Flare	Flare is control equipment
EU006	Refinery Fugitive Emissions - Cryogenic Unit, - C-23 Compressor Station, - Hydrogen Membrane Unit, - Gasoline Merox Unit, - Hydrogen Plant Feed System, - Alkylation Unit Butane Defluorinator Project, - PMA Process Unit, - Depropanizer Project, - Crude Topping Units, - Crude Vacuum Unit, - Fluidized Catalytic Cracking Unit, - Catalytic Reforming Units #1 & #2, - Alkylation Unit, - Hydrodesulfurization Units #1 & #2, - Gas Oil Hydrotreating Unit, - Delayed Coking Unit, - (Upgrading, Treating, and Recovery Units), - Cryo Debutanizer Unit, - Butamer/Feed Prep Unit, - Gas Recovery Plant Unit, - Naphtha Splitter Unit, - Sat Gas Plant Unit, - Hydrogen Purification Unit, and - Tank Farm.	None
EU007	Sulfur Recovery Facility - Jupiter SRU Flare, - Claus Units, - SRU Incinerator, - SRU/ATS Main Stack, - Ammonium Sulfate (ATS) Plant, - Ammonium Sulfide Unit, and - Claus Sulfur & Tail Gas Treating Units.	

Emission Unit ID	Description	Pollution Control Device/Practice
EU008	Storage Tanks - #100, #101, #104, #107, #110, T-3201 - #49, #4510, #4511, #162, #102, #35, #36, #72 - T-1, T-2, T-3, T-5, T-7, T-9, T-12, T-16, T-21, T-34, T-41, T-42, T-45, T-46, T-49, T-52, T-55, T-75, T-80, T-86, T-87, and T-1008 - 2 CPI Storage Tanks (#169 and #170)	None Primary and possibly secondary seals on floating roofs Vapor collection system and activated carbon control device
EU009	Product Bulk Loading - Railcar Loading Rack, - Truck Loading Rack, - Vapor Collection System, and - Vapor Combustion Unit (Enclosed Flare).	None Vapor Combustor Unit
EU010	Wastewater Treatment - Coker Unit Drain System, - Desalter Wastewater Break Tanks, - CPI oil/water Separators, - Gas Oil Hydrotreater, - 20.0 MMscfd Hydrogen Plant, - C-23 Compressor Station, - Alkylation Unit Butane Defluorinator Project, - Alkylation Unit Depropanizer Project, and - Wastewater Sewer Drains.	Carbon Canisters
EU011	Miscellaneous Process Vents	None

SECTION III. PERMIT CONDITIONS

The following requirements and conditions are applicable to the facility or to specific emission units located at the facility (ARM 17.8.1211,1212, and 1213).

A. Facility-Wide

Conditions	Rule Citation	Rule Description	Pollutant/Parameter	Limit
A.1	ARM 17.8.106	Source Testing Protocol	Testing, Recordkeeping, and Reporting Requirements	-------
A.2	ARM 17.8.304(1)	Visible Air Contaminants	Opacity	40%
A.3	ARM 17.8.304(2)	Visible Air Contaminants	Opacity	20%
A.4	ARM 17.8.308(1)	Particulate Matter, Airborne	Fugitive Opacity	20%
A.5	ARM 17.8.308(2)	Particulate Matter, Airborne	Reasonable Precautions	-------
A.6	ARM 17.8.308	Particulate Matter, Airborne	Reasonable Precaution, Construction	20%
A.7	ARM 17.8.309	Particulate Matter, Fuel Burning Equipment	Particulate Matter	$E= 0.882 * H^{-0.1664}$ or $E= 1.026 * H^{-0.233}$
A.8	ARM 17.8.310	Particulate Matter, Industrial Processes	Particulate Matter	$E= 4.10 * P^{0.67}$ or $E= 55 * P^{0.11} - 40$
A.9	ARM 17.8.322(4)	Sulfur Oxide Emissions, Sulfur in Fuel	Sulfur in Fuel (liquid or solid fuels)	1 lb/MMBtu fired
A.10	ARM 17.8.322(5)	Sulfur Oxide Emissions, Sulfur in Fuel	Sulfur in Fuel (gaseous)	50 gr/100 CF
A.11	ARM 17.8.324(3)	Hydrocarbon Emissions, Petroleum Products	Gasoline Storage Tanks	-------
A.12	ARM 17.8.324	Hydrocarbon Emissions, Petroleum Products	65,000-Gallon Capacity	-------
A.13	ARM 17.8.324	Hydrocarbon Emissions, Petroleum Products	Oil-effluent Water Separator	-------
A.14	ARM 17.8.325	Motor Vehicles	Air Pollution Control Devices	-------
A.15	ARM 17.8.749	Permit Conditions	SO_2	3103 ton/yr
A.16	40 CFR 68	Chemical Accident Prevention	Risk Management Plan	-------
A.17	40 CFR 51	State Implementation Plan (SIP)	SO_2	-------
A.18	40 CFR 51	State Implementation Plan (SIP)	Sulfur Bearing Gases	-------
A.19	40 CFR 51	State Implementation Plan (SIP)	Quantify Emissions	-------
A.20	40 CFR 51	State Implementation Plan (SIP)	Opacity	-------
A.21	ARM 17.74.336	Asbestos	Asbestos	-------
A.22	ARM 17.8.749	Recordkeeping Requirements	SO_2	-------
A.23	40 CFR 51	State Implementation Plan (SIP)	Reporting Requirements	-------
A.24	ARM 17.8.1212	Reporting Requirements	Compliance Monitoring	-------
A.25	ARM 17.8.1207	Reporting Requirements	Annual Certification	-------

Conditions

A.1. Pursuant to ARM 17.8.106, all emission source testing, sampling and data collection, recording analysis, and transmittal must be performed, maintained, and reported in accordance with the Montana Source Test Protocol and Procedures Manual (dated July 1994 unless superseded by rulemaking), unless alternate methods are approved by the Department.

A.2. Pursuant to ARM 17.8.304(1), ConocoPhillips shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed on or before November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.3. Pursuant to ARM 17.8.304(2), ConocoPhillips shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23,1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.4. Pursuant to ARM 17.8.308(1), ConocoPhillips shall not cause or authorize the production, handling, transportation, or storage of any material unless reasonable precautions to control emissions of particulate matter are taken. Such emissions of airborne particulate matter from any stationary source shall not exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.5. Pursuant to ARM 17.8.308(2), ConocoPhillips shall not cause or authorize the use of any street, road or parking lot without taking reasonable precautions to control emissions of airborne particulate matter, unless otherwise specified by rule or in this permit.

A.6. Pursuant to ARM 17.8.308, ConocoPhillips shall not operate a construction site or demolition project unless reasonable precautions are taken to control emissions of airborne particulate matter. Such emissions of airborne particulate matter from any stationary source shall not exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.7. Pursuant to ARM 17.8.309, unless otherwise specified by rule or in this permit, ConocoPhillips shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel burning equipment and new fuel burning equipment, calculated using the following equations:

For existing fuel burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

For new fuel burning equipment (installed on or after November 23, 1968):
$E = 1.026 * H^{-0.233}$

Where H is the heat input capacity in million BTU (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu.

A.8. Pursuant to ARM 17.8.310, unless otherwise specified by rule or in this permit, ConocoPhillips shall not cause or authorize particulate matter to be discharged from any operation, process, or activity into the outdoor atmosphere in excess of the maximum hourly allowable emissions of particulate matter, calculated using the following equations:

For process weight rates up to 30 tons per hour: $E = 4.10 * P^{0.67}$
For process weight rates in excess of 30 tons per hour: $E = 55.0 * P^{0.11} - 40$

Where E is the rate of emissions in pounds per hour and p is the process weight rate in tons per hour.

A.9. Pursuant to ARM 17.8.322(4), ConocoPhillips shall not burn liquid or solid fuels containing sulfur in excess of 1 pound per million BTU fired, unless otherwise specified by rule or in this permit. This rule shall be interpreted to mean that no person shall burn solid, liquid, or gaseous fuels such that the aggregate sulfur content of all fuels burned within a plant during any day exceeds 1 pound of sulfur per million BTU fired. The rule shall be interpreted to allow for a daily deviation of 0.1 pound of sulfur per million BTU fired. The rule shall be interpreted to allow the blending of all fuels burned in a plant during a given time period in determining the aggregate sulfur content for purposes of the rule, and it shall not be construed to require blending or physical mixing of fuels at any given furnace or heater within the plant complex (Environmental Protection Agency (EPA) approved SIP, September 1979).

A.10. Pursuant to ARM 17.8.322(5), ConocoPhillips shall not burn any gaseous fuel containing sulfur compounds in excess of 50 grains per 100 cubic feet of gaseous fuel, calculated as hydrogen sulfide at standard conditions, unless otherwise specified by rule or in this permit. This rule shall be interpreted to mean that no person shall burn solid, liquid, or gaseous fuels such that the aggregate sulfur content of all fuels burned within a plant during any day exceeds one pound of sulfur per million BTU fired. The rule shall be interpreted to allow for a daily deviation of 0.1 pound of sulfur per million BTU fired. The rule shall be interpreted to allow the blending of all fuels burned in a plant during a given time period in determining the aggregate sulfur content for purposes of the rule, and it shall not be construed to require blending or physical mixing of fuels at any given furnace or heater within the plant complex (Environmental Protection Agency (EPA) approved SIP, September 1979).

A.11. Pursuant to ARM 17.8.324(3), ConocoPhillips shall not load or permit the loading of gasoline into any stationary tank with a capacity of 250 gallons or more from any tank truck or trailer, except through a permanent submerged fill pipe, unless such tank is equipped with a vapor loss control device or is a pressure tank as described in ARM 17.8.324(1), unless otherwise specified by rule or in this permit.

A.12. Pursuant to ARM 17.8.324, unless otherwise specified by rule or in this permit, ConocoPhillips shall not place, store or hold in any stationary tank, reservoir or other container of more than 65,000-gallon capacity any crude oil, gasoline or petroleum distillate having a vapor pressure of 2.5 pounds per square inch absolute or greater under actual storage conditions, unless such tank, reservoir or other container is a pressure tank maintaining working pressure sufficient at all times to prevent hydrocarbon vapor or gas loss to the atmosphere, or is designed and equipped with a vapor loss control device, properly installed, in good working order and in operation.

A.13. Pursuant to ARM 17.8.324, unless otherwise specified by rule or in this permit, ConocoPhillips shall not use any compartment of any single or multiple-compartment oil-effluent water separator which compartment receives effluent water containing 200 gallons a day or more of any petroleum product from any equipment processing, refining, treating, storing or handling kerosene or other petroleum product of equal or greater volatility than kerosene, unless such compartment is equipped with a vapor loss control device, constructed so as to prevent emission of hydrocarbon vapors to the atmosphere, properly installed, in good working order and in operation.

A.14. ConocoPhillips shall comply with ARM 17.8.325. ConocoPhillips may monitor and certify compliance with ARM 17.8.325 by initially surveying its ConocoPhillips-owned on-road vehicles for the proper pollution control equipment. The survey shall be kept updated with the addition of any newly obtained ConocoPhillips-owned on-road vehicles. ConocoPhillips shall also revise its on-road vehicle maintenance procedure to state that on-road vehicle pollution control equipment removed for maintenance must be repaired and reinstalled or replaced.

A.15. Pursuant to ARM 17.8.749 (and ARM 17.8.1211), unless otherwise specified by rule or in this permit, ConocoPhillips shall not cause or authorize total SO_2 emissions from refinery and sulfur recovery facilities to exceed the limit of 3103 ton/yr. In addition, where applicable, all other federal emission limitations shall be met.

A.16. A Risk Management Plan, developed in accordance with 40 CFR 68, shall be registered with the United States Environmental Protection Agency by June 21, 1999. ConocoPhillips shall submit a certification statement to the Department that states ConocoPhillips is in compliance with the requirements of 40 CFR 68, including registration (40 CFR 68.150 and 160).

A.17. Pursuant to the June 12, 1998, Board Order adopting a sulfur dioxide control plan, ConocoPhillips shall comply with all requirements of Exhibit A, Exhibit A-1, and Attachment 1 of the plan (Board Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by EPA).

A.18. ConocoPhillips shall utilize appropriate maintenance, repair, and operating practices to control emissions of sulfur bearing gases from minor sources such as ducts, stacks, valves, vents, vessels, and flanges which are not otherwise subject to the June 12, 1998, Order from the Board adopting a sulfur dioxide control plan (Board Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by EPA).

A.19. ConocoPhillips shall use good engineering judgement and appropriate engineering calculations to quantify emissions from activities that are not otherwise addressed by the Stipulation and Exhibit A, but are known to contribute to emissions from sources listed in Exhibit A, Section 1(B). In addition, ConocoPhillips shall account for such emissions in determining compliance with all applicable emission limits contained in Exhibit A, Section 3 (Board Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by EPA).

A.20. ConocoPhillips shall monitor opacity on the FCCU stack using a Continuous Opacity Monitoring System (COMS) (ARM 17.8.103(d) and 40 CFR 51, Appendix P).

A.21. Pursuant to ARM 17.74.336, ConocoPhillips shall comply with all the limitations and requirements of their Asbestos Abatement Annual Permit #MTF0004.

A.22. ConocoPhillips shall maintain, under ConocoPhillips's control, a log of total SO_2 emissions from the refinery and sulfur recovery facilities. This log shall be used to monitor compliance with the limitation as specified in Section III.A.14 (ARM 17.8.1212).

A.23. Pursuant to the June 12, 1998, Board Order adopting a sulfur dioxide control plan, ConocoPhillips shall comply with all reporting requirements of Exhibit A, Exhibit A-1, and Attachment 1 of the plan (Board Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by EPA).

A.24. On or before January 31 and July 31 of each year, ConocoPhillips shall submit to the Department the compliance monitoring reports required by Section V.D. These reports must contain all information required by Section V.D, as well as the information required by each individual emissions unit. For the reports due by January 31 of each year, ConocoPhillips may submit a single report provided that it contains all the information required by Section V.B & V.D (ARM 17.8.1212).

any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12 (including semiannual monitoring reports), shall contain certification by a responsible official of truth, accuracy and completeness. This certification and any other certification required under ARM Title 17, Chapter 8,

Subchapter 12, shall state that, ***"based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete."***

A.25. By January 31 of each year, ConocoPhillips shall submit to the Department the compliance certification report required by Section V.B. The annual certification report required by Section V.B must include a statement of compliance based on the information available which identifies any observed, documented or otherwise known instance of noncompliance for each applicable requirement (ARM 17.8.1207).

any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12 (including annual certifications), shall contain certification by a responsible official of truth, accuracy and completeness. This certification and any other certification required under ARM Title 17, Chapter 8, Subchapter 12, shall state that, ***"based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete."***

B. EU001 – Boiler House Stack

Boiler B-1, B-2, B-5 and B-6.

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirement
B.1, B.9, B.14, B.19	SO_2 reductions in the main boiler	118.3 ton/calendar quarter	Log	Monthly	Monthly
B.1, B.9, B.14, B.19	NOx reductions in the main boiler	120.4 ton per calendar quarter			
B.2, B.9, B.14, B.19	SO_2 reductions due to reduced fuel oil firing	100 ton/yr			
B.3, B.10, B.11, B.14, B.15, B.16, B.17, B.18, B.19	SO_2	1407.8 ton/yr, 3.857 ton/day, 321.4 lb/hr on a rolling 24-hour average basis	CEMS	Ongoing	Quarterly
			Method 6/6C	Yearly	Annually
B.4, B.10, B.11, B.14, B.15, B.16, B.17, B.18, B.19	SO_2	964.2 lb/3-hr 7,713.6 lb/cal. day 2,815,464 lb/cal. yr	CEMS	Ongoing	Quarterly
			Method 6/6C	Yearly	Annually
B.5, B.11, B.14, B.15, B.16, B.17, B.18, B.19	H_2S	0.10 grains/dscf on a three-hour basis	CEMS	Ongoing	Quarterly
			Method 11	Yearly	Annually
B.6, B.12, B.14, B.16, B.17, B.19	Opacity	40%	Method 9	As required by the Department	
B.7, B.13, B.14, B.16, B.17, B.19	Particulate Matter Fuel Burning Equipment	$E= 0.882 * H^{-0.1664}$ Or $E= 1.026 * H^{-0.233}$	Method 5		
B.8, B.11, B.14, B.16, B.17, B.19	CEM	Must be equipped and operated with CEM	RATA	Annually	

Conditions

B.1. ConocoPhillips's sulfur dioxide emission reductions in the main boiler from sour water stripper gas incineration shall be at least 118.3 tons per calendar quarter (473.2 ton/year) and at least 120.4 tons per calendar quarter (481.7 ton/year) for nitrogen oxides (ARM 17.8.749 and ARM 17.8.1211).

B.2. ConocoPhillips's sulfur dioxide emission reductions in the main boiler shall be at least 100 ton/yr SO_2 reduction from reduced fuel oil firing, from the baseline SO_2 emissions of 690.0 ton/yr. The basis for the SO_2 reductions from reduced fuel oil firing is the average of SO_2 emissions from baseline year October 1987 to September 1988 (ARM 17.8.749 and ARM 17.8.1211).

B.3. SO_2 emissions from the Main Boiler House Stack are limited to 1407.8 ton/yr, 3.857 ton/day, and 321.4 lb/hr, calculated on a rolling 24-hour average (fuel oil and fuel gas combustion) (ARM 17.8.749, ARM 17.8.1211, ARM 17.8.340, and 40 CFR 60.105).

B.4. SO_2 emissions from the Main Boiler House Stack are limited to 964.2 pounds per 3-hour period, 7,713.6 pounds per calendar day, and 2,815,464 pounds per calendar year (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

B.5. ConocoPhillips shall not allow a hydrogen sulfide (H_2S) content of fuel gas burned in units emitting through the Main Boiler House Stack to exceed 0.10 grains/dscf on a 3-hour basis (ARM 17.8.749 and ARM 17.8.1211).

B.6. ConocoPhillips shall not cause or authorize emissions to be discharged into the outdoor atmosphere from the Main Boiler House Stack, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)).

B.7. ConocoPhillips shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel burning equipment and new fuel burning equipment, calculated using the following equations:

For existing fuel burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

For new fuel burning equipment (installed on or after November 23, 1968):
$E = 1.026 * H^{-0.233}$

Where H is the heat input capacity in million BTU (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

B.8. ConocoPhillips shall install and operate a sulfur dioxide continuous emission monitor and a volumetric flow rate monitor on the Main Boiler House Stack, and a refinery fuel gas monitoring system for H_2S. The sulfur dioxide and volumetric flow rate monitors shall comply with all applicable provisions of 40 CFR Part 60, Appendix B, Performance Specifications 1, 2, 3, 6 and 7 as appropriate and the quality assurance/quality control requirements of 40 CFR 60 Appendix F ((ARM 17.8.749 and ARM 17.8.1211) and (Board of Environmental Review Order signed on June 12, 1998. This requirement is "state only" until approval of the SIP by the U.S. Environmental Protection Agency)).

Compliance Demonstration

B.9. ConocoPhillips shall verify the refinery sulfur dioxide and nitrogen dioxide emission reductions from the main boiler on a monthly basis and report these results to the Department within 30 days of the end of each month. The report shall contain all necessary data from the sour water stripper gas stream and continuous stack monitor such that the sulfur dioxide and nitrogen oxides reduction can be both quantifiable and verifiable (ARM 17.8.749 and ARM 17.8.1211).

B.10. Compliance with the emission limitations contained in Section III.B.3 and 4 shall be monitored using valid data from the CEMS and corresponding appropriate equations from the Stipulation (STIP), Appendix F of this permit (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

a. The above does not relieve ConocoPhillips from meeting any applicable requirements of 40 CFR Part 60, appendices A and B, or other stack testing that may be required by the Department.

b. Other stack testing may include, but is not limited to, the following air pollutants: sulfur dioxide (SO_2), nitrogen oxides (NO_x), ammonia (NH_3), carbon monoxide (CO), particulate matter (PM, PM-10), and volatile organic compounds (VOCs).

c. Reporting requirements shall be consistent with 40 CFR Part 60, or as specified by the Department. CEMS data and calculations shall be submitted to the Department on a quarterly basis.

d. All gaseous (SO_2 and H_2S) continuous emission monitors shall be required to comply with quality assurance/quality control procedures in 40 CFR Part 60, Appendix F. Said CEMS shall be required to be maintained such that it is available and operating at least 90% of the source operating time during any reporting period (quarterly).

e. CEM systems are to be in operation at all times when the emission units are operating, except for quality assurance and control checks, breakdowns and repairs. In the event the primary CEM system is unable to meet minimum availability requirements, ConocoPhillips shall provide a back-up or alternative monitoring system and plan such that continuous compliance can be monitored. The Department shall approve such contingency plans.

B.11. In order to accurately determine the sulfur dioxide emission rates in pounds per hour for the Main Boiler House Stack, ConocoPhillips shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Methods 1-4 and 6/6C as appropriate for the Stipulation (STIP) and Exhibit A) or an equivalent method approved by the Department and EPA, and in accordance Section III.A.1 of this permit (ARM 17.8.106). The annual Relative Accuracy Test Audits (RATAs) required by Section 6(C) and (D) of the STIP may be substituted for the annual source tests, provided that the flow rate RATA and the concentration RATA are performed simultaneously and additional calculations are made to determine and report the data in pounds per hour of sulfur dioxide ((ARM 17.8.749 and ARM 17.8.1211) and (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency)).

B.12. As required by the Department, ConocoPhillips shall conduct, in accordance with Section III.A.1, a Method 9 Opacity test to monitor compliance with Section III.B.6 (ARM 17.8.1213).

B.13. As required by the Department, ConocoPhillips shall conduct, in accordance with Section III.A.1, a Method 5 Particulate Matter test or other Department approved test to monitor compliance with Section III.B.7 (ARM 17.8.1213).

Recordkeeping

B.14. Recordkeeping compiled for purposes of demonstrating compliance with emission limitations shall be retained by ConocoPhillips for a minimum of 5-years (ARM 17.8.1212).

B.15. CEMS data shall be recorded by a data collections system and shall be maintained under ConocoPhillips's control for at least 5-years after the date of data generation. This electronic data shall be made available to Department personnel upon request and shall be submitted to the Department upon request (ARM 17.8.1212).

B.16. All source testing recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).

Reporting

B.17. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

B.18. In accordance with Section 7 of the Stipulation (Appendix F of this permit), ConocoPhillips shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

B.19. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

a. Verification of compliance with SO_2 and NO_x reductions and that monthly reports were submitted as required by Section III.B.9;

b. Verification that CEMS quarterly reports were submitted as required by Section III.B.10; and

c. A summary of the results of any source tests performed during the period.

C. EU002 – FCCU Stack

FCCU Regenerator

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
C.1, C.6, C.8, C.9, C.10, C.11, C.12, C.13, C.14	SO_2	1440 ton/yr 3.945 ton/day 328.8 lb/hr on a rolling 24-hour average basis	CEMS	Ongoing	Quarterly
			Method 6/6C	Yearly	Annually
C.2, C.6, C.8, C.9, C.10, C.11, C.12, C.13, C.14	SO_2	986.4 lb/3-hr 7,891.2 lb/cal. day 2,880,288 lb/cal. yr	CEMS	Ongoing	Quarterly
			Method 6/6C	Yearly	Annually
C.3, C.6, C.9, C.10, C.11, C.12, C.13, C.14	Opacity	Cannot exceed 20%	COMS	Ongoing	Quarterly
			Method 9	As required by the Department	Annually
C.4, C.7, C.11, C.12, C.14	Particulate Matter, Industrial Processes	$E= 4.10 * P^{0.67}$ or $E= 55 * P^{0.11} - 40$	Method 5	Every 2 years	
C.5, C.8, C.9, C.10, C.11, C.12, C.13, C.14	CEMS	Must be equipped and operated with CEMS	RATA	Annually	

Conditions

C.1. SO_2 emissions from the FCCU Stack are limited to 1440 ton/yr, 3.945 ton/day, and 328.8 lb/hr, calculated on a rolling 24-hour average (ARM 17.8.749 and ARM 17.8.1211).

C.2. SO_2 emissions from the FCCU Stack are limited to 986.4 pounds per 3-hour period, 7,891.2 pounds per calendar day, and 2,880,288 pounds per calendar year (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

C.3. ConocoPhillips shall not cause or authorize emissions to be discharged into the outdoor atmosphere from the FCCU Stack that exceed an opacity of 20% averaged over 6 consecutive minutes. All opacity CEMS data associated with the monthly sandblasting operations shall be reported in the soot blowing section of the monthly CEMS performance report (ARM 17.8.749 and ARM 17.8.1211). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

C.4. ConocoPhillips shall not cause or authorize particulate matter to be discharged from any operation, process, or activity into the outdoor atmosphere in excess of the maximum hourly allowable emissions of particulate matter, calculated using the following equations:

For process weight rates up to 30 tons per hour: $E = 4.10 * P^{0.67}$
For process weight rates in excess of 30 tons per hour: $E = 55.0 * P^{0.11} - 40$

Where E is the rate of emissions in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

C.5. The FCCU stack must be equipped and operated with a sulfur dioxide continuous emission monitor, volumetric flow rate monitor and opacity monitor. The monitoring system shall meet all performance specifications, methods, and procedures. The SO_2 monitor shall meet the performance specifications in 40 CFR 60, Appendix B, Performance Specification 2 and 7, and the quality assurance/quality control requirements (on a concentration basis) of 40 CFR 60, Appendix F ((ARM 17.8.749 and ARM 17.8.1211), (ARM 17.8.103(d) and 40 CFR 51, Appendix P), and (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of SIP by U.S. Environmental Protection Agency)).

Compliance Demonstration

C.6. Compliance with the emission limitations contained in Section III.C.1, III.C 2, and III.C.3 shall be monitored using data from the CEMS, COMS, and other Department approved sampling methods. However, opacity compliance may also be determined, via EPA reference Method 9, by a certified observer or monitor (ARM 17.8.749 and ARM 17.8.1211).

a. The above does not relieve ConocoPhillips from meeting any applicable requirements of 40 CFR 60, Appendices A and B, or other stack testing that may be required by the Department.

b. Other stack testing may include, but is not limited to, the following air pollutants: SO_2, NO_x, NH_3, CO, PM, PM-10, and VOCs.

c. Reporting requirements shall be consistent with 40 CFR Part 60, or as specified by the Department. CEMS data and calculations shall be submitted to the Department on a quarterly basis.

d. All gaseous (SO_2) continuous emission monitors shall be required to comply with quality assurance/quality control procedures in 40 CFR Part 60, Appendix F. Said CEMS shall be required to be maintained such that it is available and operating at least 90% of the source operating time during any reporting period (quarterly).

e. CEM systems are to be in operation at all times when the emission units are operating, except for quality assurance and control checks, breakdowns and repairs. In the event the primary CEM system is unable to meet minimum availability requirements, ConocoPhillips shall provide a back-up or alternative monitoring system and plan such that continuous compliance can be monitored. The Department shall approve such contingency plans.

C.7. In accordance with Section III.A.1, ConocoPhillips shall perform Method 5 testing or other Department approved testing every 2-years on the FCCU stack to monitor compliance with Section III.C.4 (ARM 17.8.1213).

C.8. In order to accurately determine the sulfur dioxide emission rates in pounds per hour for the FCCU Stack, ConocoPhillips shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Methods 1-4 and 6/6C as appropriate for the Stipulation (STIP)

and Exhibit A) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 of this permit (ARM 17.8.106). The annual Relative Accuracy Test Audits (RATAs) required by Section 6(C) and (D) of the STIP may be substituted for the annual source tests, provided that the flow rate RATA and the concentration RATA are performed simultaneously or concurrently and additional calculations are made to determine and report the data in pounds per hour of sulfur dioxide (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

Recordkeeping

C.9. Recordkeeping compiled for purposes of demonstrating compliance with emission limits shall be retained by ConocoPhillips for a minimum of 5-years (ARM 17.8.1212).

C.10. CEMS data shall be recorded by a data collections system and shall be maintained under ConocoPhillips's control for at least 5-years after the date of data generation. This electronic data shall be made available to Department personnel upon request and shall be submitted to the Department upon request (ARM 17.8.1212).

C.11. All Source Test recordkeeping shall be performed in accordance with the test method being used and Section III.A.1 (ARM 17.8.106).

Reporting

C.12. All Source Test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

C.13. In accordance with Section 7 of the Stipulation (Appendix F of this permit), ConocoPhillips shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

C.14. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

a. Verification that CEMS quarterly reports were submitted as required by Section III.C.13; and

b. A summary of the results of any source tests performed during the period.

D. EU003 – 24 Fuel Gas Combustion Units

H-1, H-2, H-4, H-5, H-10, H-11, H-12, H-13, H-14, H-15, H-16, H-17, H-18, H-19, H-20, H-21, H-22, H-23, H-24, Coker Heater: H-3901, Fractionator Heater: H-8401, Recycle Hydrogen Heater: H-8402, Hydrogen Plant Heater: H-9401, and PB Merox Unit.

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
D.1, D.2, D.16, D.29, D.30, D.32, D.33, D.34, D.35	SO_2	45.5 ton/yr, 614 lb/day	Method 6/6C	As required by the Department	Annually
			CEMS	Ongoing	Quarterly
D.3, D.16, D.17, D.18, D.29, D.30, D.32, D.33, D.34, D.35	SO_2	87.0 lb/3-hr 696.0 lb/Cal. Day 254,040 lb/Cal. yr	Method 6/6C	As required by the Department	Annually
			CEMS	Ongoing	Quarterly
D.4, D.19, D.29, D.30, D.32, D.33, D.34, D.35	H_2S	0.10 grains/dscf on a 3-hour basis	Method 11	Yearly	Annually
			CEMS	Ongoing	Quarterly
D.5, D.20, D.21, D.30, D.32, D.34, D.35	NOx	0.08 lb/MMBtu 7.38 lb/hr	Method 7	As required by the Department	Semiannual
			Low NO_x burners	Ongoing	
D.6, D.20, D.21, D.30, D.32, D.34, D.35	NOx	0.03 lb/MMBtu	Method 7	As required by the Department	
			Ultra Low NO_x burners	Ongoing	
D.7, D.16, D.20, D.30, D.32, D.34	Furnace fuel gas PSA purge gas	5 ppmv of sulfur compound, sulfur free purge gas	Method 6/6C	As required by the Department	
			Ultra Low NO_x burners	Ongoing	
D.8, D.20, D.21, D.30, D.32, D.34, D.35	Total NOx	13.54 lb/hr, 58.95 ton/yr	Method 7	As required by the Department	
			Ultra Low and Low NO_x burners	Ongoing	
D.9, D.22, D.30, D.32, D.34, D.35	Opacity	40%	Method 9	As required by the Department	
D.10, D.22, D.30, D.32, D.34, D.35	Opacity	20%	Method 9		
D.11, D.23, D.30, D.32, D.34, D.35	Particulate Matter, Fuel Burning	$E= 0.882 * H^{-0.1664}$ or $E= 1.026 * H^{-0.233}$	Method 5		
D.12, D.24, D.29, D.30, D.32, D.33, D.34, D.35	CEMS	Must be equipped and operated with CEMS	RATA	Annually	Annually
D.13, D.27, D.34	Coke Heater (H-3901), Recycle Hydrogen Heater (H8402), Fractionator Feed Heater (H8401)	Low NO_x burners	Log	Monthly inspections and any maintenance	Semiannual

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
D.14, D.25, D.31, D.32, D.34	Coke Heater (H-3901), Recycle Hydrogen Heater (H8402), Fractionator Feed Heater (H8401)	40 CFR 60, Subpart J	40 CFR 60, Subpart J	40 CFR 60, Subpart J	
D.15, D.26, D.28, D.34	PB Merox Unit	Record readings	Log	Every shift	

Conditions

D.1. ConocoPhillips may not cause or authorize SO_2 emissions from the 24 refinery fuel gas heaters/furnaces in excess of 45.5 ton/year on a rolling 12-month average (ARM 17.8.749 and ARM 17.8.1211).

D.2. ConocoPhillips may not cause or authorize SO_2 emissions from the 24 refinery fuel gas heaters/furnaces in excess of 614 lb/day on a rolling 24-hour average (fuel gas combustion and the PB Merox Unit disulfide separator off gas incineration) (ARM 17.8.749 and ARM 17.8.1211).

D.3. Combined emissions of SO_2 for the process heaters shall not exceed 87.0 pounds per 3-hour period, 696.0 pounds per calendar day, 254,040 pounds per calendar year (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

D.4. Hydrogen sulfide content of the fuel gas burned in the 24 Refinery Fuel Gas Heaters/Furnaces shall not exceed 0.10 grains/dscf on a 3-hour basis (NSPS fuel, 160 ppmv H_2S) (ARM 17.8.749, ARM 17.8.1211, ARM 17.8.340, and 40 CFR 60, Subpart J).

D.5. NO_x emissions from the Coker Heater shall not exceed the limit of 0.08 lb/MMBtu and 7.38 lb/hr (ARM 17.8.752 and ARM 17.8.1211).

D.6. NO_x emissions from the Recycle Hydrogen Heater, Fractionator Feed Heater, or Hydrogen Plant Heater shall not exceed the limit of 0.03 lb/MMBtu (ARM 17.8.752 and ARM 17.8.1211).

D.7. The furnace fuel gas shall be low sulfur gas with a maximum 5 ppmv of sulfur compound. The PSA purge gas, used as furnace fuel, shall be sulfur free (ARM 17.8.752 and ARM 17.8.1211).

D.8. The total NO_x emissions from the Coker Heater, Recycle Hydrogen Heater, Fractionator Feed Heater, and Hydrogen Plant Heater shall not exceed the limit of 13.54 lb/hr and 58.95 ton/yr (ARM 17.8.749 and ARM 17.8.1211).

D.9. Opacity from 19 of the Refinery Fuel Gas Heaters/Furnaces (H-1, H-2, H-4, H-5, H-10, H-11, H-12, H-13, H-14, H-15, H-16, H-17, H-18, H-19, H-20, H-21, H-22, H-23, H-24) shall not exceed 40% averaged over any 6 consecutive minutes (ARM 17.8.304(1)).

D.10. Opacity from the Coker Heater, Recycle Hydrogen Heater, Fractionator Feed Heater, and Hydrogen Plant Heater shall not exceed 20% averaged over any 6 consecutive minutes (ARM 17.8.304(2)).

D.11. ConocoPhillips shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel burning equipment and new fuel burning equipment, calculated using the following equations:

For existing fuel burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

For new fuel burning equipment (installed on or after November 23, 1968):
$E = 1.026 * H^{-0.233}$

Where H is the heat input capacity in million BTU (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

D.12. The Fuel Gas Heaters/Furnaces must be equipped and operated with a continuous Hydrogen Sulfide (H_2S) concentration and flow rate monitor. The monitoring system shall meet all performance specifications, methods and procedures. The Hydrogen Sulfide fuel gas monitoring system shall meet the 40 CFR Part 60, Appendix B, Performance Specification 7 and the quality assurance/quality control requirements (on a concentration basis) of 40 CFR 60, Appendix F ((ARM 17.8.749 and ARM 17.8.1211) and (Board of Environmental Review Order signed on June 12, 1998. This requirement s "State Only" until approval of the SIP by the U.S. Environmental Protection Agency)).

D.13. ConocoPhillips shall equip and maintain ultra low NO_x burners on the Recycle Hydrogen Heater and Fractionator Feed Heater and low NO_x burners on the Coker Heater (ARM 17.8.749 and ARM 17.8.1211).

D.14. ConocoPhillips shall comply with all applicable requirements of 40 CFR 60, Subpart J, as they apply to the Coker Heater, Recycle Hydrogen Heater, and the Fractionator Feed Heater and any other applicable equipment (ARM 17.8.749, ARM 17.8.1211, ARM 17.8.702(a), ARM 17.8.340, and 40 CFR 60, Subpart J).

D.15. ConocoPhillips shall record the PB Merox Unit Stream Rotameter reading at least once during every shift. This reading shall be used to determine the mass flow rate of the stream and shall be used in coordination with sampling of the PB Merox Unit disulfide separator off-gas stream to determine total sulfur (ppmw) present. After ConocoPhillips has collected the data for a period of 1-year, the Department may review the data and reduce the monitoring frequency of the PB Merox Unit disulfide stream if ConocoPhillips can monitor that the flow rate is consistent (ARM 17.8.749 and ARM 17.8.1211).

Compliance Demonstration

D.16. As required by the Department, ConocoPhillips shall perform source testing on the fuel gas combustion units using Method 6/6C or other Department approved test methods, to monitor compliance with Section III.D.1, III.D.2 and III.D.7 (ARM 17.8.1213).

D.17. Compliance with the combined emission limitation for the refinery fuel gas fired units, contained in Section III.D.3, shall be monitored by using hourly average H_2S concentration and hourly average fuel gas flow rate data from the CEMS required by Section III.D.12 and in accordance with the appropriate equations contained in the SIP (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

D.18. Demonstration of compliance with Section III.D.3 shall be determined by utilizing valid data taken from continuous emission monitors (CEMS) and other Department approved sampling methods (ARM 17.8.749 and ARM 17.8.1211).

a. The above does not relieve ConocoPhillips from meeting any applicable requirements of 40 CFR Part 60, Appendices A and B, or other stack testing that may be required by the Department.

b. Other stack testing may include, but is not limited to, the following air pollutants: sulfur dioxide (SO_2), nitrogen oxides (NO_x), ammonia (NH_3), carbon monoxide (CO), particulate matter (PM, PM-10), and volatile organic compounds (VOCs).

c. Reporting requirements shall be consistent with 40 CFR Part 60, or as specified by the Department.

d. All gaseous continuous emission monitors shall be required to comply with quality assurance/quality control procedures in 40 CFR Part 60, Appendix F. Said CEMS shall be required to be maintained such that it is available and operating at least 90% of the source operating time during any reporting period (quarterly).

e. CEM systems are to be in operation at all times when the emission units are operating, except for quality assurance and control checks, breakdowns, and repairs. In the event the primary CEM system is unable to meet minimum availability requirements, ConocoPhillips shall provide a back-up or alternative monitoring system and plan such that continuous compliance can be monitored. The Department shall approve such contingency plans.

D.19. In order to accurately determine the hydrogen sulfide concentration in parts per million for the fuel gas-system, ConocoPhillips shall perform annual source testing using, EPA-approved methods (40 CFR Part 60, Appendix A, Method 11) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 of this permit (ARM 17.8.106) (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

D.20. Compliance with Sections III.D.5, III.D.6, II.D.7 and III.D.8 shall be monitored by utilization of Ultra Low and Low NO_x burners on the fuel gas combustion units (ARM 17.8.1213).

D.21. As required by the Department, ConocoPhillips shall perform source testing on the fuel gas combustion units using Method 7 or other Department approved test methods to monitor compliance with Section III.D.5, III.D.6, and III.D.8 (ARM 17.8.1213).

D.22. As required by the Department, ConocoPhillips shall perform source testing on the fuel gas combustion units using Method 9 to monitor compliance with Section III.D.9 and III.D.10 (ARM 17.8.1213).

D.23. As required by the Department, ConocoPhillips shall perform source testing on the fuel gas combustion units using Method 5 or other Department approved test methods, to monitor compliance with Section III.D.11 (ARM 17.8.1213).

D.24. Annually, ConocoPhillips shall perform RATA source testing on the H_2S CEMS (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

D.25. ConocoPhillips shall perform compliance demonstrations in accordance with 40 CFR 60, Subpart J to monitor compliance with the requirements of 40 CFR 60, Subpart J (ARM 17.8.340 and 40 CFR 60, Subpart J).

D.26. ConocoPhillips shall maintain a log, under ConocoPhillips's control, recording the readings taken from the PB Merox Unit Stream Rotameter (ARM 17.8.1213).

Recordkeeping

D.27. ConocoPhillips shall maintain, under ConocoPhillips's control, a log of monthly inspection and any maintenance performed on the Ultra Low and Low NO_x burners (ARM 17.8.1212).

D.28. ConocoPhillips shall maintain, under ConocoPhillips's control, all logs required for compliance demonstration, shall make all logs available to Department personnel during inspections, and shall submit the logs to the Department upon request (ARM 17.8.1212).

D.29. CEMS data shall be recorded by a data collections system and shall be maintained under ConocoPhillips's control for at least 5-years after the date of data generation. This electronic data shall be made available to Department personnel upon request and shall be submitted to the Department upon request (ARM 17.8.1212).

D.30. All source testing recordkeeping shall be performed in accordance with the appropriate test method being used and Section III.A.1 (ARM 17.8.106).

D.31. Recordkeeping shall be performed in accordance with 40 CFR 60, Subpart J for the applicable requirements as they apply to the Coker Heater, Recycle Hydrogen Heater, and the Fractionator Feed Heater (ARM 17.8.340 and 40 CFR 60, Subpart J).

Reporting

D.32. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

D.33. In accordance with Section 7 of the Stipulation, ConocoPhillips shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only" until approval of the SIP by the U.S. Environmental Protection Agency).

D.34. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of results of any source testing that was performed during the period;

b. Verification that quarterly reports of CEMS data was submitted;

c. Certification that Ultra Low and Low NO_x burners were utilized during the period;

d. Certification that the log containing readings from the PB Merox Unit Rotameter was maintained; and

e. Compliance with 40 CFR 60, Subpart J was maintained.

D.35. ConocoPhillips shall provide monthly emission reports from said emission rate monitors. Emission reporting for sulfur dioxide from all point source locations shall consist of 24-hour calendar day totals per calendar month. The monthly report shall also include the following (ARM 17.8.749 and ARM 17.8.1211):

a. Source or unit operating times during the reporting period;

b. Monitoring down time which occurred during the reporting period;

c. A summary of excess emissions for each pollutant and averaging period identified in III.D.1 through III.D.11;

d. Emission estimates for nitrogen oxides and ammonia from material balance, engineering calculation data, and any emission testing; and

e. Reasons for any emissions in excess of those specifically allowed in III.D.1 through III.D.11 with mitigative measures utilized and corrective actions taken to prevent a recurrence of the upset situation.

ConocoPhillips shall submit monthly emission reports within 30 days of the end of each calendar month.

E. EU004 – PMA Process Heater (H-3201) & Storage Tank Vent

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
E.1, E.8, E.15, E.16, E.17	NOx	80 lb/MMscf 0.76 lb/hr	Method 7	As required by the Department	Semiannual
E.2, E.9, E.17	Heater	Natural Gas Fired Only	Certify	Annually	
E.3, E.10, E.15, E.16, E.17	Heater Opacity	20%	Method 9	As required by the Department	
E.4, E.11, E.17	Stack Height	50 feet	Certify	Annually	
E.5, E.10, E.15, E.16, E.17	Vent Opacity	0%	Method 9	As required by the Department	
E.6, E.12, E.14, E.17	PMA process heater	Low NO_x burners with FGR	Log	Monthly inspections (when operating) and any maintenance (when maintenance occurs)	
E.7, E.13, E.15, E.16, E.17	Particulate Matter, Fuel Burning	$E= 0.882 * H^{-0.1664}$ or $E= 1.026 * H^{-0.233}$	Method 5	As required by the Department	

Conditions

E.1. NO_x emissions from the PMA Process Heater Stack shall not exceed the limit of 80 lb/MMscf or 0.76 lb/hr (ARM 17.8.752 and ARM 17.8.1211).

E.2. The PMA Process Heater shall be fired on purchased natural gas only and shall not be fired on refinery fuel gas (ARM 17.8.749 and ARM 17.8.1211).

E.3. ConocoPhillips shall not cause or authorize emissions to be discharged into the outdoor atmosphere from the PMA Process Heater Stack, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304).

E.4. ConocoPhillips shall maintain a stack height of 50 feet above grade on the PMA Process Heater Stack (ARM 17.8.749 and ARM 17.8.1211).

E.5. ConocoPhillips shall not cause or authorize emissions to be discharged into the outdoor atmosphere from the PMA Storage Tank Vent that exhibit an opacity of 0% or greater averaged over 6 consecutive minutes, except for one consecutive 15-minute period in any 24-hour period when the transfer lines are being blown clear (ARM 17.8.340 and 40 CFR 60.472(c)).

E.6. ConocoPhillips shall equip and maintain low NO_x burners with Flue Gas Recirculation (FGR) on the PMA process heater (ARM 17.8.752 and ARM 17.8.1211).

E.7. ConocoPhillips shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel burning equipment and new fuel burning equipment calculated using the following equations:

For existing fuel burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

For new fuel burning equipment (installed on or after November 23, 1968):
$E = 1.026 * H^{-0.233}$

Where H is the heat input capacity in million BTU (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

Compliance Demonstration

E.8. As required by the Department, ConocoPhillips shall perform a Method 7 source test or other Department approved test method, to monitor compliance with the limitations as specified in Section III.E.1 (ARM 17.8.1213).

E.9. ConocoPhillips shall certify annually that only Natural Gas was fired in the PMA Process Heater for the period (ARM 17.8.1213).

E.10. As required by the Department, ConocoPhillips shall perform Method 9 source testing to monitor compliance with the limitations as specified in Section III.E.3 and III.E.5 for the PMA Process Heater and the Storage Tank Vent, respectively (ARM 17.8.1213).

E.11. ConocoPhillips shall certify annually that the PMA Process Heater Stack height is maintained at 50 feet above grade (ARM 17.8.1213).

E.12. ConocoPhillips shall maintain, under ConocoPhillips's control, a log of monthly inspections and maintenance performed on the low NO_x burners with FGR to monitor compliance with Section III.E.6, when the PMA process heater is operating or as required by the Department. If maintenance is performed on the low NO_x burners with FGR when the PMA process heater is not operating, this activity shall be logged at the time of maintenance (ARM 17.8.1213).

E.13. As required by the Department, ConocoPhillips shall perform source testing on the PMA Process Heater using Method 5 or other Department approved test methods, to monitor compliance with Section III.E.7 (ARM 17.8.1213).

Recordkeeping

E.14. ConocoPhillips shall maintain, under ConocoPhillips's control, a log containing date, time, inspector's initials and the results of the inspection and any corrective action taken (ARM 17.8.1212).

E.15. All source test recordkeeping shall be performed in accordance with the appropriate test method being used and Section III.A.1 (ARM 17.8.106).

Reporting

E.16. All source test reports shall be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

E.17. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of results of any source testing that was performed during the period;

b. Certification that only natural gas was fired in the PMA Process Heater during the period;

c. Certification that the stack height is maintained at 50 feet above grade; and

d. Verification that logs were maintained as required by Sections III.E.13 and III.E.15.

F. EU005 – Refinery Flare

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
F.1, F.7, F.8, F.13, F.16	H_2S	0.10 grains/dscf on a 3-hour basis	Method 11	As required by the Department	Semiannual
			Acoustic Meter	Yearly	
F.2, F.9, F.12, F.15, F.16	SO_2	Offset SO_2 emissions greater than 100 ton/yr	Log	As necessary	
F.3, F.4, F.10, F.12, F.15, F.16	SO_2	Minor Flaring and 150 lb/3-hr	Reporting & Corrective Action		At least Quarterly & as necessary
			Acoustic meter		
F.5, F.16	Flare	Equipped and Operated with a Steam Injection System. Tip to Base: at 148 feet above grade	Certify	Semiannual	Semiannual
F.6, F.11, F.14, F.16	Flow rate	Flow rate metering shall use approved standards, methods, accounting procedures, and engineering data	Log	Monthly	Monthly

Conditions

F.1. H_2S content in the fuel gas burned in the Refinery Flare shall not exceed 0.10 grain/dscf on a 3-hour basis (ARM 17.8.752 and ARM 17.8.1211).

F.2. SO_2 emission increases, due to upset conditions or discontinuance of the SRU, shall be offset by an equivalent rate from any other sources covered by this permit (ARM 17.8.749 and ARM 17.8.1211).

F.3. ConocoPhillips shall not allow SO_2 emissions from any flare, unless the emissions are a minor flaring event, or are the result of start-up, shutdown, or a malfunction as defined in ARM 17.8.110. A minor flaring event means a flaring event that emits less than or equal to 150 pounds of SO_2 per 3-hour period (Board of Environmental Review Order signed on June 12, 1998, this requirement is "State Only").

F.4. Except for minor flaring events, ConocoPhillips shall minimize SO_2 emissions from flaring. In addition, when flaring of sulfur bearing gases occurs due to a malfunction, ConocoPhillips shall take immediate action to correct the malfunction (Board of Environmental Review Order signed on June 12, 1998, this requirement is "State Only").

F.5. The Emergency Refinery Flare must be equipped and operated with a steam injection system. The flare tip height shall be 148 feet above grade (ARM 17.8.752 and ARM 17.8.1211).

F.6. Any flow rate metering from upset or malfunctioning process units that are directed to either the refinery flare or the SRU flare shall use approved standards, methods, accounting procedures, and engineering data (ARM 17.8.749 and ARM 17.8.1211).

Compliance Demonstration

F.7. In order to accurately determine the H_2S concentration and as required by the Department, ConocoPhillips shall perform a Method 11 source test on the fuel gas system or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 (ARM 17.8.1213).

F.8. ConocoPhillips shall use an acoustic meter to detect losses of gases through the pressure relief valves and control valves that connect process stream piping to the flare, and are designated to be normally closed (Consent Agreement, signed 1/7/00 by EPA).

F.9. ConocoPhillips shall maintain, under ConocoPhillips's control, a record of SO_2 offsets as required by Section III.F.2 (ARM 17.8.1213).

F.10. For purposes of determining whether a flaring event greater than 150 pounds of SO_2 per 3-hour period has occurred, ConocoPhillips shall maintain records of all activities, other than de minimis activities, that result in SO_2 emissions from the flare (Board of Environmental Review Order signed on June 12, 1998, this requirement is "State Only").

F.11. ConocoPhillips shall provide monthly emission reports for the flare SO_2 emissions based on H_2S concentration information and flow information. The monthly emission reports shall be submitted within 30 days of the end of each calendar month. The monthly report shall consist of 24-hour calendar day totals per calendar month and shall include the following (ARM 17.8.749 and ARM 17.8.1211):

a. Source or unit operating time during the reporting period;

b. Monitoring downtime that occurred during the reporting period;

c. A summary of excess emissions for each pollutant and averaging period; and

d. Emission estimates for sulfur dioxide, other than de minimis activities, from material balance, engineering calculation data, and any emission testing.

Recordkeeping

F.12. ConocoPhillips shall maintain a record of all flaring events other than flaring caused by de minimis activities. Each entry shall include the date; time; duration; an engineering estimate of the 3-hour emissions; the measured flow rate to the flare, if available; a description of the source and estimated equivalent sulfur content of the gases directed to the flare; a reason for the flaring event; a description of the immediate actions taken to correct the situation; and the operator's initials (Board of Environmental Review Order signed on June 12, 1998, this requirement is "State Only").

F.13. ConocoPhillips shall maintain the database used to enter acoustical meter reading information, which will ultimately determine if there is a leak from pressure relief/control valves. The database records shall be maintained for 5-years after the date of record and shall be submitted to the Department upon request (ARM 17.8.1212).

F.14. ConocoPhillips shall maintain, under ConocoPhillips's control, a log of the monthly inspection and maintenance performed on the flow rate-metering device used on upset or malfunctioning process units that are directed to either the refinery flare or the SRU flare (ARM 17.8.1212).

Reporting

F.15. For flaring events in excess of 150lb/3-hr period, ConocoPhillips shall comply with the reporting requirements identified in Section (3)(A)(5) of Exhibit A-1 of the Stipulation (Board of Environmental Review Order Signed on June 12, 1998. This requirement is "State Only").

F.16. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of results of any source testing that was performed during the period;

b. A summary of results from the acoustic meter testing that was performed during the period;

c. Certification that the flare is equipped and operated with steam injection and the flare tip height is 148 feet above grade; and

d. Verification that monthly reports were submitted as required by Section III.F.11.

G. EU006 – Refinery Fugitive Emissions

C-23 Compressor Station, Delay Coker Unit, Cryogenic Unit, Hydrogen Membrane Unit, Gasoline Merox Unit, Crude Topping Unit, Crude Vacuum Unit, Fluidized Catalytic Cracking Unit, Catalytic Reforming Unit, Hydrodesulfurization Unit, Gas Oil Hydrotreater Unit (consisting of a reaction section, fractionation section, and an amine treating section), 20.0 MMscfd Hydrogen Plant Feed System, Alkylation Unit Butane Defluorinator (consisting of heat exchangers; X-453, X-223, X-450, X-451, X-452, pumps; P-646, Vessels; D-130, D-359, D-360), PMA Process Unit, Alkylation Unit Depropanizer, Cryo Debutanizer Unit, Butamer/Feed Prep Unit, Gas Recovery Plant Unit, Naphtha Splitter Unit, Sat Gas Plant Unit, Hydrogen Purification Unit, and Tank Farm.

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
G.1, G.10, G.16, G.20	All Valves	High quality with high quality packing.	Log	As purchased and installed	Semiannual
G.2, G.10, G.16, G.20	Open-Ended Valves	High quality with high quality packing. Plugs, caps or a second valve on the open end.			
G.3, G.10, G.16, G.20	Pipe and Tower Flanges	Compatible gasket material			
G.4, G.10, G.13, G.20	Pumps	Mechanical seals			
G.5, G.11, G.16, G.20	VOC monitoring and maintenance program	Instituted (Acoustic Meter)		During performance of program	
		Monitoring & Maintenance Plan			
G.6, G.12, G.16, G.20	Failure or leakage of compressor seal system	Repair		Each repair	
G.7, G.13, G.20	Gasoline Handling	Minimize vapor releases	Certify	Appropriate measures were taken	
G.8, G.14, G.17, G.19, G.20	Haul Road PM Opacity	20%	Method 9	As required by the Department	
G.9, G.15, G.17, G.18, G.19, G.20	Equipment Leaks	40 CFR 63.648	40 CFR 63.654	40 CFR 63.654	40 CFR 63.654

Conditions

G.1. All valves used shall be high quality valves containing high quality packing (for the C-23 Compressor Station) (ARM 17.8.749, ARM 17.8.752, and ARM 17.8.1211).

G.2. All open-ended valves used shall be high quality valves containing high quality packing. They will have plugs, caps, or a second valve installed on the open end (for the C-23 Compressor Station) (ARM 17.8.749, ARM 17.8.752, and ARM 17.8.1211).

G.3. All pipe and tower flanges used shall be installed using process compatible gasket material (for the C-23 Compressor Station) (ARM 17.8.749, ARM 17.8.752, and ARM 17.8.1211).

G.4. All pumps used shall be fitted with the highest quality state-of-the-art mechanical seals, as appropriate (for the C-23 Compressor Station) (ARM 17.8.749, ARM 17.8.752, and ARM 17.8.1211).

G.5. A VOC monitoring and maintenance program shall be instituted as described in 40 CFR 60.482-2, 40 CFR 60.482-4 through 10, 40 CFR 60.483-1 and 2, 40 CFR 60.485, 40 CFR 60.486 (b-k) and 40 CFR 60.486 (c-e) (ARM 17.8.340 and 40 CFR 60, Subpart VV).

G.6. If monitoring or scheduled inspections indicate failure or leakage of the compressor seal system, then the seals shall be repaired as soon as practicable, but not later than 15 days after it is detected, except as provided in 40 CFR 60.482-9 (ARM 17.8.752 and ARM 17.8.1211).

G.7. ConocoPhillips shall not allow gasoline to be handled in a manner that would result in vapor releases to the atmosphere for extended periods of time (ARM 17.8.752 and ARM 17.8.1211).

G.8. All access roads shall use either paving or chemical dust suppression to limit excessive fugitive dust with water as a back-up measure to maintain compliance with ARM 17.8.308 and the 20% opacity limitation. Construction and earth-moving activities shall use reasonable precautions to limit excessive fugitive dust to mitigate impacts to nearby residential and commercial places (ARM 17.8.749, ARM 17.8.1211, and ARM 17.8.308).

G.9. ConocoPhillips shall comply with all applicable requirements of 40 CFR 63.648 as they apply to the Tank Farm, Large Crude/Vacuum Unit, Small Crude Unit, #1 & #2 Reformer Unit, #1 & #2 HDS Unit, Cryo Debutanizer Unit, Butamer/Feed Prep Unit, FCCU, Gas Recovery Plant Unit, Alkylation Unit, PB Merox Unit, Naphtha Splitter Unit, Sat Gas Plant Unit, and Hydrogen Purification Unit required to comply with the equipment leak regulations (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

G.10. ConocoPhillips shall maintain records that monitor acceptable leak rates required by 40 CFR 63.648, for affected valves and pump mechanical seals, as well as flanges, including flange gasket materials. This obligation shall be used to monitor compliance with Section III.G.1, III.G.2, III.G.3 and III.G.4 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

G.11. ConocoPhillips shall institute the monitoring and maintenance plan in accordance with 40 CFR 60, Subpart VV and shall use the acoustic meter in addition to the 40 CFR 60, Subpart VV (ARM 17.8.340 and 40 CFR 60, Subpart VV).

G.12. ConocoPhillips shall maintain a log, under ConocoPhillips's control, of all leakage repairs associated with the compressor seal system. The log shall contain the date, time, repair personnel's initials and type of repair made (ARM 17.8.1213).

G.13. Measures to be taken to minimize vapor release include, but are not limited to the following (ARM 17.8.1213):

a. Minimize gasoline spills.

b. Clean up spills as expeditiously as practicable.

c. Cover all open gasoline containers with a gasketed seal when not in use.

d. Minimize gasoline sent to open waste collection systems that collect and transport gasoline to reclamation and recycling devices, such as oil/water separators (ARM 17.8.342).

G.14. As required by the Department, ConocoPhillips shall perform a Method 9 opacity test on the haul roads to monitor compliance with the 20% opacity limitation as specified in Section III.G.8 (ARM 17.8.1213).

G.15. Compliance demonstration for equipment leaks shall be performed in accordance with 40 CFR 63.654, 63.644, and/or 63.645, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

G.16. ConocoPhillips shall maintain, under ConocoPhillips's control, all logs required for compliance demonstration, shall make all logs available to Department personnel during inspections, and shall submit the logs to the Department upon request (ARM 17.8.1212).

G.17. ConocoPhillips shall perform all source testing recordkeeping in accordance with the appropriate test method and Section III.A.1 (ARM 17.8.106).

G.18. Recordkeeping for equipment leaks shall be performed in accordance with 40 CFR 63.654, 63.644, and/or 63.645, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

G.19. ConocoPhillips shall submit all source test reports in accordance with Section III.A.1 (ARM 17.8.106).

G.20. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of results of the last source testing that was performed;

b. A summary of all logs used to monitor compliance with limitations and conditions of this section;

c. Certification that gasoline handling was performed to minimize vapor release in accordance with section III.G.13; and

d. Certification of compliance with 40 CFR 63, Subpart CC.

H. EU007 – Sulfur Recovery Facility

Jupiter SRU flare, Claus units, SRU Incinerator

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
H.1, H.18, H.43	Jupiter SRU flare	Steam injection, flare height of 213 ft	Verification	Semiannual	Semiannual
H.2, H.3, H.18, H.35, H.41, H.43	Jupiter SRU flare	Minor flaring and 150 lb/3-hr	Reporting and Corrective Action	As necessary	
H.4, H.19, H.36, H.43	Flow rate	Flow rate metering shall use approved standards, methods, accounting procedures, and engineering data	Log	Monthly	Monthly
H.5, H.21, H.38, H.43	Claus units	40 CFR 60, Subpart J	Subpart J	Subpart J	Semiannual
H.6, H.22, H.37, H.40, H.42, H.43	SRU Incinerator	Equipped with low NO_x burners	Verification and inspection	Semiannual & annual	

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
H.7, H.23, H.39, H.42, H.43	SO_2 from SRU/ATS main stack	0.300 ton/day, 25.00 lb/hr	CEMS	Ongoing	
			Method 6/6C	Yearly	
H.8, H.24, H.39, H.42, H.43	NO_x from SRU/ATS main stack	82.85 ton/yr, 454.0 lb/day, 18.92 lb/hr	Method 7	Every permit term	
H.9, H.25, H.39, H.42, H.43	PM/PM-10 from SRU/ATS main stack	34.00 ton/yr, 186.3 lb/day, 7.76 lb/hr	Method 5 and Method 201A	As required by the Department	
H.10, H.26, H.39, H.42, H.43	CO from the SRU/ATS main stack	1.76 ton/yr, 0.40 lb/hr	Method 10		
H.11, H.27, H.40, H.43	NH_3 from SRU/ATS main stack	58.5 ton/yr, 320.5 lb/day, 13.36 lb/hr	Material Balance	Semiannual	
H.12, H.28, H.39, H.42, H.43	Opacity of SRU/ATS main stack and SRU flare	20%	Method 9	As required by the Department	
H.13, H.29, H.39, H.42, H.43	SO_2 from SRU flare	0.300 ton/day, 25.00 lb/hr	Material balance		
H.14, H.30, H.43	PM and CO	Negligible	Verification	Semiannual	
H.15, H.31, H.39, H.42, H.43	H_2S content of the flare fuel gas (and pilot gas)	0.10 grain/dscf on a 3-hour basis	Method 11	As required by the Department	
H.16, H.32, H.40, H.43	Total SO_2 from SRU/ATS main stack plus the SRU flare	109.5 ton/yr (rolling 12-month average)	Log	Monthly	
H.17, H.33, H.34, H.39, H.42, H.43	SRU/ATS SO_2 CEMS	Must be equipped and operated with SRU/ATS SO_2 CEMS	RATA	Yearly	
			Emission Report	Monthly	
H.17, H.33, H.34, H.39, H.42, H.43	SRU/ATS O_2 CEMS	Must be equipped and operated with SRU/ATS O_2 CEMS	RATA	Yearly	
			Emission Report	Monthly	
H.17, H.33, H.34, H.39, H.42, H.43	SRU/ATS Volumetric flow rate monitor	Must be equipped and operated with SRU/ATS Volumetric flow rate monitor	RATA	Yearly	

Conditions

H.1. Jupiter SRU flare must be equipped and operated with a steam injection system. Flare tip height shall be 213 feet from grade (ARM 17.8.749 and ARM 17.8.1211).

H.2. ConocoPhillips shall not allow SO_2 emissions from any flare, unless the emissions are a minor flaring event, or are the result of start-up, shutdown, or a malfunction as defined in ARM 17.8.110. A minor flaring event means a flaring event that emits less than or equal to 150 pounds of SO_2 per 3-hour period (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only").

H.3. Except for minor flaring events, ConocoPhillips shall minimize SO_2 emissions from flaring. In addition, when flaring of sulfur bearing gases occurs due to a malfunction, ConocoPhillips shall take immediate action to correct the malfunction (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only").

H.4. Any flow rate metering from upset or malfunctioning process units that are directed to either the refinery flare or the SRU flare shall use approved standards, methods, accounting procedures, and engineering data (ARM 17.8.749 and ARM 17.8.1211).

H.5. ConocoPhillips shall comply with all applicable requirements of 40 CFR 60.100 through 60.108, Subpart J, as they apply to Clause units at the Jupiter sulfur recovery facility and any other applicable equipment (ARM 17.8.749 and ARM 17.8.1211).

H.6. The SRU Incinerator (F-304) shall be equipped with low NO_x burners (ARM 17.8.749 and ARM 17.8.1211).

H.7. SO_2 emissions from the SRU/ATS main stack shall be limited to 0.300 ton/day, 25.00 lb/hr (167 ppm, rolling 12-hour average corrected to 0% oxygen on a dry basis) (ARM 17.8.749 and ARM 17.8.1211).

H.8. NO_x emissions from the SRU/ATS main stack shall be limited to 82.85 ton/yr, 454.0 lb/day, 18.92 lb/hr (ARM 17.8.749 and ARM 17.8.1211).

H.9. PM-10 emissions from the SRU/ATS main stack shall be limited to 34.00 ton/yr, 186.3 lb/day, 7.76 lb/hr (ARM 17.8.749 and ARM 17.8.1211).

H.10. CO emissions from the SRU/ATS main stack shall be limited to 1.76 ton/yr, 0.40 lb/hr (ARM 17.8.749 and ARM 17.8.1211).

H.11. Ammonia (NH_3) emissions from the SRU/ATS main stack shall be limited to 58.5 ton/yr, 320.5 lb/day, 13.36 lb/hr (ARM 17.8.749 and ARM 17.8.1211).

H.12. ConocoPhillips shall not cause or authorize emissions to be discharged into the outdoor atmosphere from the SRU/ATS main stack or the SRU flare that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.749 and ARM 17.8.1211).

H.13. SO_2 emissions from the SRU flare shall be limited to 0.300 ton/day, 25.00 lb/hr (ARM 17.8.749 and ARM 17.8.1211).

H.14. PM and CO emissions shall be kept to their negligible levels (ARM 17.8.749 and ARM 17.8.1211).

H.15. H_2S content of the flare fuel gas (and pilot gas) burned shall not exceed 0.10 grain/dscf on a 3-hour basis (ARM 17.8.749 and ARM 17.8.1211).

H.16. Total SO_2 emissions from the SRU/ATS main stack, plus the SRU flare, shall not exceed 109.5 ton/yr (rolling 12-month average) (ARM 17.8.749 and ARM 17.8.1211).

H.17. ConocoPhillips shall equip and operate the SRU/ATS stack with a sulfur dioxide continuous emission monitor, an oxygen continuous emission monitor and a volumetric flow rate continuous emission rate monitor (ARM 17.8.749 and ARM 17.8.1211).

Compliance Demonstration

H.18. ConocoPhillips shall verify semiannually that the Jupiter SRU flare is steam injected and the flare height is 213 ft above grade (ARM 17.8.1213).

H.19. For purposes of determining whether a flaring event greater than 150 pounds of SO_2 per 3-hour period has occurred, ConocoPhillips shall maintain records of all activities, other than de minimis activities, that result in SO_2 emissions from the flare (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only").

H.20. ConocoPhillips shall provide monthly emission reports for the flare SO_2 emissions based on H_2S concentration information and flow information. The monthly emission reports shall be submitted within 30 days of the end of each calendar month. The monthly report shall consist of 24-hour calendar day totals per calendar month and shall include the following: (ARM 17.8.749 and ARM 17.8.1211):

a. Source or unit operating time during the reporting period;

b. Monitoring downtime that occurred during the reporting period;

c. A summary of excess emissions for each pollutant and averaging period; and

d. Emission estimates for sulfur dioxide, other than de minimis activities, from material balance, engineering calculation data, and any emission testing.

H.21. ConocoPhillips shall comply with the test methods and monitoring requirements of 40 CFR 60.105, 60.106, and 60.108 to monitor compliance with the standards contained in 40 CFR 60.102, 60.103, and 60.104 (ARM 17.8.340 and 40 CFR 60, Subpart J).

H.22. ConocoPhillips shall verify semiannually and inspect annually the low NO_x burners on the incinerator (ARM 17.8.1213).

H.23. ConocoPhillips shall use continuous emission monitoring data to monitor compliance with the limitations of Section III.H.7. ConocoPhillips shall also perform annual RATAs using Method 6/6C or other Department approved method (ARM 17.8.1213).

H.24. ConocoPhillips shall perform a Method 7 source test or other Department approved method on an every-permit-term basis to monitor compliance with limitations contained in Section III.H.8 (ARM 17.8.1213).

H.25. As required by the Department, ConocoPhillips shall perform a Method 5 and Method 201A source test or other Department approved method to monitor compliance with the limitations contained in Section III.H.9 (ARM 17.8.1213).

H.26. As required by the Department, ConocoPhillips shall perform a Method 10 source test or other Department approved method to monitor compliance with the limitations contained in Section III.H.10 (ARM 17.8.1213).

H.27. ConocoPhillips shall monitor compliance with Section III.H.11 by performing material balance calculations for ammonia (ARM 17.8.1213).

H.28. As required by the Department, ConocoPhillips shall perform a Method 9 source test to monitor compliance with the limitations contained in Section III.H.12 (ARM 17.8.1213).

H.29. As required by the Department, ConocoPhillips shall perform a Method 11 source test, material balance, or other Department approved method to demonstration compliance for SO_2 limit at the SRU flare (ARM 17.8.1213).

H.30. ConocoPhillips shall verify that emissions of PM and CO are maintained at a negligible level to monitor compliance with Section III.H.14 (ARM 17.8.1213).

H.31. As required, ConocoPhillips shall perform a Method 11 or other Department approved method to monitor compliance with the limitation contained in Section III.H.15 (ARM 17.8.1213).

H.32. ConocoPhillips shall maintain a log, under ConocoPhillips's control, containing total SO_2 emissions from the SRU/ATS main stack plus the SRU flare for the year using a rolling 12-month average (ARM 17.8.1213).

H.33. Flow rate metering from upset or malfunctioning process units that are directed to the flare shall use approved standards, methods, accounting procedures, and engineering data (ARM 17.8.1213).

H.34. ConocoPhillips shall provide monthly emission reports from said emission rate monitors. Emission reporting for sulfur dioxide from all point source locations shall consist of 24-hour calendar day totals per calendar month. The monthly report shall be submitted within 30 days of the end of the calendar month and include the following: (ARM 17.8.749 and ARM 17.8.1211):

a. Source or unit operating times during the reporting period;

b. Monitoring downtime that occurred during the reporting period;

c. A summary of excess emissions for each pollutant and averaging period identified under each emission unit;

d. Emission estimates for nitrogen oxides and ammonia from material balance, engineering calculation data, and any emission testing; and

e. Reasons for any emissions in excess of those specifically allowed, with mitigative measures utilized and corrective actions taken to prevent a recurrence of the upset situation.

Recordkeeping

H.35. ConocoPhillips shall maintain a record of all flaring events other than flaring caused by de minimis activities. Each entry shall include the date; time; duration; an engineering estimate of the 3 hour emissions; the measured flow rate to the flare, if available; a description of the source and estimated equivalent sulfur content of the gases directed to the flare; a reason for the flaring event; a description of the immediate actions taken to correct the situation; and the operator's initials (Board of Environmental Review Order signed on June 12, 1998. This requirement is "State Only").

H.36. ConocoPhillips shall maintain, under ConocoPhillips's control, a log of the monthly inspection and maintenance performed on the flow rate-metering device used on upset or malfunctioning process units that are directed to either the refinery flare or the SRU flare (ARM 17.8.1212).

H.37. ConocoPhillips shall maintain, under ConocoPhillips's control, verification and inspection records for the low NO_x burners on the SRU Incinerator (ARM 17.8.1212).

H.38. ConocoPhillips shall maintain recordkeeping in accordance with 40 CFR 60.107 (ARM 17.8.340 and 40 CFR 60, Subpart J).

H.39. ConocoPhillips shall perform all source testing recordkeeping in accordance with the appropriate test method and Section III.A.1 (ARM 17.8.106).

H.40. ConocoPhillips shall maintain, under ConocoPhillips's control, all logs required for compliance demonstration, shall make all logs available to Department personnel during inspections, and shall submit the logs to the Department upon request (ARM 17.8.1212).

Reporting

H.41. For flaring events in excess of 150 lb/3-hr period, ConocoPhillips shall comply with the reporting requirements identified in Section (3)(A)(5) of the Exhibit A-1 of the Stipulation (Board of Environmental Review Order Signed on June 12, 1998. This requirement is "State Only").

H.42. All Source Test reports shall be submitted to the Department in accordance Section III.A.1 (ARM 17.8.106).

H.43. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of results of the last source testing that was performed;

b. Verification that the flare is operated with steam injection;

c. Certification of compliance with 40 CFR 60, Subpart J;

d. Verification that the SRU Incinerator is equipped with low NO_x burners;

e. Summary of the material balance as required by Section III.H.11;

f. Summary of the monthly logs required by Section III.H.32; and

g. Verification that the monthly emission reports were submitted as required by Section III.H.34.

I. EU008 – Storage Tanks

MACT Group1 Storage Vessels: Tanks 1, 2, 3, 5, 7, 9, 12, 16, 21, 34, 35, 36, 41, 42, 45, 46, 49, 52, 55, 72, 75, 80, 86, 87, 102, and 1008; MACT Group 2 Storage Vessels: Tanks 91, 92, 100, 101, 104, 107, 110, 162, 3201; 40 CFR 60, Subpart QQQ (Wastewater) Storage Vessels: Tanks 15, 163, 164, 4510, 4511, 4512, 4513, (2) CPI Separator Tanks: 169 and 170; Other: Tank 4514

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirement
I.1, I.9, I.15, I.20	Tank 49	Internal floating roof with double rim seal	Verification and Inspection	Semiannual	Semiannual
I.2, I.9, I.15, I.20	Tanks 4510, 4511, 4512, and 4513	Internal floating roof with double rim seals or liquid mounted seal system.			
I.3, I.9, I.15, I.20	Tank 162	Fixed roof with a roof-top vacuum breaker vent			
I.4, I.10, I.16, I.20	Tanks 91, 92	40 CFR 60, Subpart K	40 CFR 60.113	As specified	Semiannual
I.5, I.11, I.16, I.20	Tanks 100, 101, 102, 104	40 CFR 60, Subpart Ka	40 CFR 60.113a and/or 40 CFR 60.114a	As specified	Semiannual
I.6, I.12, I.16, I.19, I.20	Tanks 35, 36, 72, 107, 110, 162, 3201, 4514	40 CFR 60, Subpart Kb	40 CFR 60.113b and/or 40 CFR 60.114b	As specified	40 CFR 60.115b
I.7, I.13, I.17, I.20	Tank 3201	40 CFR 60, Subpart UU	40 CFR 60.474	As specified	Semiannual
I.8, I.14, I.18, I.20	Group 1 Storage Vessels	40 CFR 63.646, Subpart CC	40 CFR 63.646, Subpart CC	40 CFR 63.646, Subpart CC	40 CFR63.654, Subpart CC

Conditions

I.1. Storage tank #49 shall be equipped with an internal floating roof with a double rim seal system for VOC loss control (ARM 17.8.752 and ARM 17.8.1211).

I.2. Storage tank #4510, #4511, #4512, and #4513 shall be equipped with an internal floating roof with a double rim seal system or liquid mounted seal system for VOC loss control. (ARM 17.8.752 and ARM 17.8.1211).

I.3. Storage tank #162 shall be equipped with a fixed roof with a roof-top vacuum breaker vent (ARM 17.8.752 and ARM 17.8.1211).

I.4. All volatile organic storage vessels (including petroleum liquid storage vessels) for which construction, reconstruction or modification commenced after June 11, 1973, and prior to May 19, 1978, shall comply with requirements of 40 CFR 60, Subpart K. These requirements shall be as specified in 40 CFR 60.110 through 60.113. The affected tanks include, but are not limited to, tanks 91 and 92 (ARM 17.8.340 and 40 CFR 60, Subpart K).

I.5. All volatile organic storage vessels (including petroleum liquid storage vessels) for which construction, reconstruction or modification commenced after May 18, 1978, and prior to July 23, 1984 shall comply with requirements of 40 CFR 60, Subpart Ka. These requirements shall be as specified in 40 CFR 60.110a through 60.115a. The affected tanks include, but are not limited to, the following (ARM 17.8.340 and 40 CFR 60, Subpart Ka):

Tank Number
#100-Ka*
#101-Ka*
#102-Ka
#104-Ka*

* Currently exempt from all emission control provisions due to vapor pressure of material stored.

I.6. All volatile organic storage vessels (including petroleum liquid storage vessels) for which construction, reconstruction or modification commenced after July 23, 1984 shall comply with requirements of 40 CFR 60, Subpart Kb. These requirements shall be as specified in 0 CFR 60.110b through 60.115b. The affected tanks include, but are not limited to, the following (ARM 17.8.340 and 40 CFR 60, Subpart Kb):

Tank Number
#35-Kb
#36-Kb
#72-Kb
#107-Kb*
#110-Kb*
#162-Kb*
#164-Kb*
#T-3201*
#4514-Kb*

* Currently exempt from all emission control provisions due to vapor pressure of material stored.

I.7. The asphalt storage tank T-3201 and any other applicable storage tanks which commenced construction or modification after May 26, 1981, shall comply with all applicable requirements of 40 CFR 60, Subpart UU. Asphalt storage tank T-3201 shall comply with the standards of 40 CFR 60.472(c) (ARM 17.8.340 and 40 CFR 60, Subpart UU).

I.8. All Group 1 Storage Vessels shall comply with all applicable requirements of 40 CFR 63, Subpart CC (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

I.9. ConocoPhillips shall perform semiannual inspections on Tanks #49, #4510, #4511, #4512, #4513 and #162 to determine integrity of the roofs, seal systems associated with the floating roofs, and vents (ARM 17.8.1213).

I.10. ConocoPhillips shall monitor compliance with Section III.I.4 by complying with 40 CFR 60.113 (ARM 17.8.340 and 40 CFR 60, Subpart K).

I.11. ConocoPhillips shall monitor compliance with Section III.I.5 by complying with 40 CFR 60.113a and/or 40 CFR 60.114a (ARM 17.8.340 and 40 CFR 60, Subpart Ka).

I.12. ConocoPhillips shall monitor compliance with Section III.I.6 by complying with 40 CFR 60.113b and/or 40 CFR 60.114b (ARM 17.8.340 and 40 CFR 60, Subpart Kb).

I.13. ConocoPhillips shall monitor compliance with Section III.I.7 by complying with 40 CFR 60. 474 (ARM 17.8.340 and 40 CFR 60, Subpart UU).

I.14. ConocoPhillips shall monitor compliance with storage vessel provisions of 40 CFR 63.646 (ARM 17.8.342 and 40 CFR 60, Subpart CC).

Recordkeeping

I.15. ConocoPhillips shall maintain, under ConocoPhillips's control, a log of all inspections performed on the tanks listed in Section III.I.9. This log shall contain the date, time, inspector's initials and the results of the inspection. If corrective action or repairs are made, a summary should be included in the log (ARM 17.8.1212).

I.16. ConocoPhillips shall maintain a log, under ConocoPhillips's control, for the monitoring required by 40 CFR 60.113, 40 CFR 60.115a, 40 CFR 60.115b, and 40 CFR 60.116b (ARM 17.8.340 and 40 CFR 60; Subpart K, Ka, and Kb).

I.17. ConocoPhillips shall maintain a log, under ConocoPhillips's control, for the monitoring required by 40 CFR 60.473 (ARM 17.8.340 and 40 CFR 60, Subpart UU).

I.18. ConocoPhillips shall comply with recordkeeping requirements of 40 CFR 63.646 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

I.19. ConocoPhillips shall submit reports in accordance with 40 CFR 60.115b (ARM 17.8.340 and 40 CFR 60, Subpart Kb).

I.20. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of results of the last source testing that was performed;

b. Verification that inspections were performed;

c. Verification that the testing procedures of 40 CFR 60.113, 40 CFR 60.113a and/or 114a, and 60.113b and/or 114b were followed;

d. Verification that 40 CFR 60.474 were followed; and

e. All required information for compliance demonstrations for 40 CFR 63, Subpart CC. Nothing in this subparagraph requires the permittee to submit its MACT compliance report earlier than is required by the MACT regulations found in 40 CFR Subpart CC.

J. EU009 – Product Bulk Loading

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
J.1, J.12, J.18, J.21, J.23	Loading Rack	Subpart R	40 CFR 63.425, 427, & 428	Every 4 years	Semiannual
J.2, J.12, J.18, J.21, J.23	Loading Rack and VCU	Operate and Maintain as Listed	40 CFR 63, Subpart R	40 CFR 63, Subpart R	
J.3, J.13, J.19, J.23	Cargo Tanks	Submerged fill and dedicated normal service	Verification	During loading	
J.4, J.14, J.19, J.23	Flare flame	Present during loading			
J.5, J.6, J.15, J.19, J.23	Valves, flanges, pump seals, & open-ended lines	Inspection	Log	Monthly during inspections	
J.7, J.12, J.18, J.21, J.23	Gasoline handling	Minimal vapor releases to atmosphere		As needed	
J.8, J.12, J.18, J.21, J.23	VOC	10.0 mg/L of gasoline loaded	40 CFR 63.425	Every 4 years	
J.9, J.16, J.20, J.22, J.23	CO	10.0 mg/L of gasoline loaded	Method 10	As required by the Department	
J.10, J.16, J.20, J.22, J.23	NO_x	4.0 mg/L of gasoline loaded	Method 7		
J.11, J.17, J.20, J.22, J.23	Opacity	20%	Method 9		

Conditions

J.1. ConocoPhillips shall comply with all applicable requirements of 40 CFR Part 63, National Emission Standards for Hazardous Air Pollutants for Source Categories, Subpart R-National Emission Standards for Gasoline Distribution Facilities (Bulk Gasoline Terminals and Pipeline Breakout Stations) (ARM 17.8.342 and 40 CFR 63, Subpart R).

J.2. ConocoPhillips's bulk loading rack and distillates loading rack shall be operated and maintained as follows:

a. ConocoPhillips's loading rack shall be equipped with a vapor collection system designed to collect the organic compound vapors displaced from cargo tanks during product loading (ARM 17.8.342 and 40 CFR 63, Subpart R).

b. ConocoPhillips's collected vapors shall be routed to the VCU at all times. In the event that the VCU was inoperable, ConocoPhillips may continue to load only distillates provided that the Department is notified in accordance with the requirements of ARM 17.8.110 (ARM 17.8.752 and ARM 17.8.1211).

c. The vapor collection and liquid loading equipment shall be designed and operated to prevent gauge pressure in the gasoline cargo tank from exceeding 4,500 Pascals (Pa) (450 millimeters (mm) of water) during product loading. This level shall not be exceeded when measured by the procedures specified in the test methods and procedures in 40 CFR 60.503(D) (ARM 17.8.342 and 40 CFR 63, Subpart R).

d. No pressure-vacuum vent in the permitted terminal's vapor collection system shall begin to open at a system pressure less than 4,500 Pa (450 mm of water) (ARM 17.8.342 and 40 CFR 63, Subpart R).

e. The vapor collection system shall be designed to prevent any volatile organic compound (VOC) vapors, collected at one loading position, from passing to another loading position (ARM 17.8.342 and 40 CFR 63, Subpart R).

f. Loading of liquid products into cargo tanks shall be limited to vapor-tight gasoline cargo tanks using the following procedures (ARM 17.8.342 and 40 CFR 63, Subpart R):

i. ConocoPhillips shall obtain annual vapor tightness documentation, described in the test methods and procedures in 40 CFR 63.425(e), for each gasoline cargo tank that is to be loaded at the loading rack.

ii. ConocoPhillips shall require the cargo tank identification number to be recorded as each gasoline cargo tank is loaded at the terminal.

iii. ConocoPhillips shall cross-check each tank identification number obtained during product loading with the file of tank vapor tightness documentation within 2 weeks after the corresponding cargo tank is loaded.

iv. ConocoPhillips shall notify the owner or operator of each non-vapor-tight cargo tank loaded at the loading rack within 3 weeks after the loading has occurred.

v. ConocoPhillips shall take the necessary steps to ensure that any non-vapor-tight cargo tank will not be reloaded at the loading rack until vapor tightness documentation for that cargo tank is obtained which documents that:

1. The gasoline cargo tank meets the applicable test requirements in 40 CFR 63.425(e).

2. For each gasoline cargo tank failing the test requirements in 40 CFR 63.425(f) or (g), the gasoline cargo tank must either:

aa. Before the repair work is performed on the cargo tank, meet the test requirements in 40 CFR 63.425 (g) or (h), or

bb. After repair work is performed on the cargo tank before or during the tests in 40 CFR 63.425 (g) or (h), subsequently passes the annual certification test described in 40 CFR 63.425(e).

g. ConocoPhillips shall ensure that loading of gasoline cargo tanks at the loading rack are made only into cargo tanks equipped with vapor collection equipment that is compatible with the terminal's vapor collection system (ARM 17.8.342 and 40 CFR 63, Subpart R).

h. ConocoPhillips shall ensure that the terminal's and the cargo tank's vapor recovery systems are connected during each loading of a gasoline cargo tank at the loading rack (ARM 17.8.342 and 40 CFR 63, Subpart R).

J.3. Loading of cargo tanks shall be restricted to the use of submerged fill and dedicated normal service (ARM 17.8.749 and ARM 17.8.1211).

J.4. ConocoPhillips shall install and continuously operate a thermocouple and an associated recorder, or an ultraviolet flame detector and relay system which will render the loading rack inoperable if a flame is not present at the VCU flare tip, or any other equivalent device, to detect the presence of a flame (ARM 17.8.342; 40 CFR 63, Subpart R; ARM 17.8.752; and ARM 17.8.1211).

J.5. ConocoPhillips shall perform a monthly leak inspection of all equipment in gasoline service. The inspection must include, but is not limited to, all valves, flanges, pump seals, and open-ended lines. For purposes of this inspection, detection methods incorporating sight, sound, or smell are acceptable. Each piece of equipment shall be inspected during the loading of a gasoline cargo tank (ARM 17.8.342 and 40 CFR 63, Subpart R).

J.6. Delay of repair of leaking equipment will be allowed upon a demonstration to the Department that repair within 15 days is not feasible. The owner or operator shall provide the reason(s) a delay is needed and the date by which each repair is expected to be completed (ARM 17.8.342 and 40 CFR 63, Subpart R).

J.7. ConocoPhillips shall not allow gasoline to be handled in a manner that would result in vapor releases to the atmosphere for extended periods of time. Measures to be taken include, but are not limited to the following (ARM 17.8.342 and 40 CFR 63, Subpart R):

a. Minimize gasoline spills.

b. Clean up spills as expeditiously as practicable.

c. Cover all open gasoline containers with a gasketed seal when not in use.

d. Minimize gasoline sent to open waste collection systems that collect and transport gasoline to reclamation and recycling devices, such as oil/water separators.

J.8. Volatile Organic Compound (VOC) emissions to the atmosphere from the VCU due to loading liquid product into cargo tanks shall not exceed 10.0 milligrams per liter (mg/L) of gasoline loaded (ARM 17.8.342; 40 CFR 63, Subpart R; ARM 17.8.752; and ARM 17.8.1211).

J.9. Carbon Monoxide (CO) emissions to the atmosphere from the VCU due to loading liquid product into cargo tanks shall not exceed 10.0 milligrams per liter (mg/L) of gasoline loaded (ARM 17.8.752 and ARM 17.8.1211).

J.10. Nitrogen Oxide (NO_x) emissions to the atmosphere from the VCU due to loading liquid product into cargo tanks shall not exceed 4.0 milligrams per liter (mg/L) of gasoline loaded (ARM 17.8.752 and ARM 17.8.1211).

J.11. ConocoPhillips shall not cause or authorize to be discharged into the atmosphere from the enclosed VCU any visible emissions that exhibit an opacity of 20% or greater (ARM 17.8.304).

Compliance Demonstration

J.12. ConocoPhillips shall comply with all test methods and procedures as specified by Subpart R §63.425 (a) through (c), and §63.425 (e) through (h). This shall apply to, but not be limited to, the bulk gasoline and distillate truck loading rack, the vapor processing system, and all gasoline equipment. The gasoline truck loading VCU shall be tested for total organic compounds, and compliance monitored with the emission limitation contained in Section III.J.8 on an every 4-year basis. ConocoPhillips shall perform the test methods and procedures as specified in 40 CFR 63.425 (ARM 17.8.105, ARM 17.8.342, and 40 CFR 63, Subpart R).

J.13. ConocoPhillips shall verify that the submerged fill and dedicated normal service is continually used when loading cargo tanks at the loading rack (ARM 17.8.1213).

J.14. ConocoPhillips shall verify that a thermocouple recorder, an ultraviolet flame detector with relay system, or any other equivalent device to detect flame, is installed and continuously operated to meet the requirements of Section III.J.4 (ARM 17.8.1213).

J.15. A logbook shall be used and shall be signed by the owner or operator at the completion of each inspection required by Section III.J.5. A section of the log shall contain a list, summary description, or diagram(s) showing the location of all equipment in gasoline service at the facility. Each detection of a liquid or vapor leak shall be recorded in the logbook. When a leak is detected, an initial attempt at repair shall be made as soon as practicable, but no later than 5 calendar days after the leak is detected. Repair or replacement of leaking equipment shall be completed within 15 calendar days after detection of each leak, except as provided in Section III.J.6 (ARM 17.8.342 and 40 CFR 63, Subpart R).

J.16. As required by the Department, the loading rack VCU shall be tested for CO and NO_x, concurrently, using Method 10 and 7, respectively, in accordance with Section III.A.1 (ARM 17.8.106), to monitor compliance with the emission limitations contained in Section III.J.9 and III.J.10 (ARM 17.8.1213).

J.17. As required by the Department, the loading rack VCU shall be tested for opacity using Method 9, in accordance with Section III.A.1 (ARM 17.8.106), to monitor compliance with the 20% limit contained in Section III.J.11 (ARM 17.8.1213).

Recordkeeping

J.18. ConocoPhillips shall keep all records as required by 40 CFR 63, Subpart R (ARM 17.8.342 and 40 CFR 63, Subpart R).

J.19. ConocoPhillips shall maintain all logs, under ConocoPhillips's control, as required to monitor compliance with applicable limitations and shall submit the log, upon request, by the Department (ARM 17.8.1212).

J.20. ConocoPhillips shall perform all recordkeeping during testing as required by the Method and Section III.A.1 (ARM 17.8.106).

Reporting

J.21. ConocoPhillips shall furnish all reports to the Department as required by 40 CFR 63, Subpart R (ARM 17.8.342 and 40 CFR 63, Subpart R).

J.22. ConocoPhillips shall submit all source test reports in accordance with Section III.A.1 (ARM 17.8.106).

J.23. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

a. Compliance with 40 CFR 63, Subpart R, was maintained;

b. Verification of compliance with conditions in this section;

c. Verification that logs were maintained as required for this section; and

d. A summary of results of the last source testing that was performed.

K. EU0010 – Wastewater Treatment

Coker unit drain system, desalter wastewater break tanks, CPI separators, gas oil hydrotreater, 20.0 MMscfd hydrogen plant, C-23 compressor station, Alkylation Unit Butane Defluorinator Project, Alkylation Unit Depropanizer Project, and associated wastewater tanks.

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
K.1, K.4, K.7, K.8	Wastewater Treatment	40 CFR 60, Subpart QQQ	40 CFR 60, Subpart QQQ	40 CFR 60, Subpart QQQ	Semiannual
K.2, K.5, K.9	Wastewater Treatment	40 CFR 61, Subpart FF	40 CFR 61, Subpart FF	40 CFR 61, Subpart FF	
K.3, K.6, K.9	CPI Separator Tanks #169 & #170	Carbon Canisters designed and operated to reduce VOC emissions by 95%	Certify	Semiannual	

Conditions

K.1. ConocoPhillips shall comply with all applicable requirements of 40 CFR 60, Subpart QQQ. This subpart applies to, but is not limited to, the coker unit drain system, desalter wastewater break tanks (#4510 and #4511), CPI separators, gas oil hydrotreater, 20.0 MMscfd hydrogen plant, C-23 compressor station, Alkylation Unit Butane Defluorinator Project, Alkylation Unit Depropanizer Project, tanks #163, #164, #169, #170, #4512, and #4513; and any other applicable equipment (ARM 17.8.340 and 40 CFR 60, Subpart QQQ).

a. All process drains shall consist of tightly sealed caps or P-leg traps for sewer drains with intermittent flow.

b. The primary oil/water separator shall be an oil/water (CPI) separator with hydrocarbon collection and recovery equipment.

c. All equipment shall be operated and maintained as required under 40 CFR Part 60, Subpart QQQ.

K.2. ConocoPhillips shall comply with all applicable requirements of 40 CFR 61, Subpart FF. This subpart applies to, but is not limited to, all new or recommissioned wastewater sewer drains associated with the Alkylation Unit Depropanizer Project; the refinery's existing sewer system; and tanks #164, #4512, and #4513 (ARM 17.8.341 and 40 CFR 61, Subpart FF).

K.3. ConocoPhillips shall operate and maintain two (2) CPI separator tanks with carbon canister total VOC controls to comply with 40 CFR 60, Subpart QQQ and 40 CFR 61, Subpart FF regulations. The CPI separators will be vented to two (2) carbon canisters in series, designed and operated to reduce VOC emissions by 95% or greater, with no detectable emissions from the closed vent system (ARM 17.8.340; 40 CFR 60, Subpart QQQ; ARM 17.8.341; and 40 CFR 61, Subpart FF).

Compliance Demonstration

K.4. ConocoPhillips shall meet the requirements of all testing and procedures of ARM 17.8.340, which references 40 CFR part 60, NSPS, Subpart QQQ, Standards of Performance for Volatile Organic Compound Emissions from Petroleum Refinery Wastewater Systems. This shall apply to, but not be limited to, the coker unit drain system, desalter wastewater break tanks (#4510 and #4511), CPI separators, gas oil hydrotreater, 20.0 MMscfd hydrogen plant, C-23 compressor station, tanks #163, #164, #169, #170, #4512, and #4513; and the alkylation units (butane defluorinator and depropanizer) (ARM 17.8.340 and 40 CFR 60, Subpart QQQ).

K.5. ConocoPhillips shall monitor the exhaust vent stream from the waste water CPI separators carbon adsorption system (T-169 & T-170 carbon canisters) on a regular schedule according to the requirements contained in 40 CFR 60, Subpart QQQ, Section 60.695(a)(3)(ii) and 40 CFR 61, Subpart FF, Section 61.354(d). The existing carbon shall be replaced with fresh carbon immediately when carbon breakthrough is indicated. The device shall be monitored at intervals not to exceed 14.4 hours, when the wastewater treatment is operational. The time period may be revised, by the Department, in the event that the carbon absorption system is upgraded or physically altered (ARM 17.8.340; 40 CFR 60, Subpart QQQ; ARM 17.8.341; and 40 CFR 61, Subpart FF).

K.6. ConocoPhillips shall certify that carbon canisters are continuously used on the CPI Separator Tanks and that they are operated to reduce VOC emissions by 95% or greater (ARM 17.8.1213).

Recordkeeping

K.7. ConocoPhillips shall conduct all applicable recordkeeping requirements in accordance with 40 CFR 60, Subpart QQQ (ARM 17.8.340 and 40 CFR 60, Subpart QQQ).

Reporting

K.8. ConocoPhillips shall provide the Department copies of testing results, monitoring operations, recordkeeping, and report results as specified under 40 CFR 60, Subpart QQQ, Sections 60.693-2, 60.696, 60.697, and 60.698 (ARM 17.8.340 and 40 CFR 60, Subpart QQQ).

K.9. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of reporting done to conform to requirements of 40 CFR 60, Subpart QQQ;

b. A summary of reporting done to conform to requirements of 40 CFR 61, Subpart FF;

c. Certification that carbon canisters were operated to reduce VOCs by 95%; and

d. A summary of results of any source testing that was performed during the period.

L. EU0011 – Miscellaneous Process Vents

Condition(s)	Pollutant/ Parameter	Permit Limit	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
L.1, L.2, L.3, L.4, L.5, L.6	Miscellaneous Process Vents	40 CFR 63.643	40 CFR 63.644 &645	40 CFR 63.644 &645	40 CFR 63.654

Conditions

L.1. ConocoPhillips shall comply with all applicable requirements of 40 CFR 63.643 as they apply to the units required to comply with the Miscellaneous Process Vents (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

L.2. Compliance demonstration for miscellaneous process vents shall be performed in accordance with 40 CFR 63.654, 63.644, and/or 63.645, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

L.3. Recordkeeping for miscellaneous process vents shall be performed in accordance with 40 CFR 63.654, 63.644, and/or 63.645, as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

L.4. ConocoPhillips shall perform all source testing recordkeeping in accordance with the appropriate test method and Section III.A.1 (ARM 17.8.106).

Reporting

L.5. ConocoPhillips shall submit all source test reports in accordance with Section III.A.1 (ARM 17.8.106).

L.6. The annual compliance certification report required by Section V.B must contain a certification statement for the above applicable requirements. The semiannual reporting shall provide (ARM 17.8.1212):

a. A summary of results of the last source testing that was performed;

b. A summary of all logs used to monitor compliance with limitations and conditions of this section; and

c. Certification of compliance with 40 CFR 63, Subpart CC.

SECTION IV. NON-APPLICABLE REQUIREMENTS

Air Quality Administrative Rules of Montana (ARM) and Federal Regulations identified as not applicable to the facility or to a specific emissions unit at the time of the permit issuance are listed below (ARM 17.8.1214). The following list does not preclude the need to comply with any new requirements that may become applicable during the permit term.

A. Facility-Wide

The following table contains non-applicable requirements that are administrated by the Air and Waste Management Bureau of the Department of Environmental Quality.

Rule Citation	Reason
ARM 17.8.320, ARM 17.8.321, ARM 17.8.323, ARM 17.8 331, ARM 17.8.332, ARM 17.8.333, and ARM 17.8.334.	These rules are not applicable because the facility is not listed in the source category cited or does not have the specific emissions unit cited in the rules.
40 CFR 60, Subparts B, C, Ca, Cb 40 CFR 60, Subparts D, Da, Db, Dc 40 CFR 60, Subparts E-I 40 CFR 60, Subparts L-Z 40 CFR 60, Subparts AA-EE 40 CFR 60, Subparts GG-HH 40 CFR 60, Subparts KK-NN 40 CFR 60, Subparts PP-TT 40 CFR 60, Subparts WW 40 CFR 60, Subparts AAA- DDD 40 CFR 60, Subparts FFF 40 CFR 60, Subparts HHH-LLL 40 CFR 60, Subparts NNN-PPP 40 CFR 60, Subparts RRR-WWW 40 CFR 61, Subparts B-F 40 CFR 61, Subparts H-L 40 CFR 61, Subparts N 40 CFR 61, Subparts O-R 40 CFR 61, Subpart T 40 CFR 61, Subparts V-W 40 CFR 61, Subpart Y 40 CFR 61, Subpart BB	These requirements are not applicable because the facility is not an affected source as defined in these regulations.
40 CFR 63, Subpart B 40 CFR 63, Subparts F-I 40 CFR 63, Subparts L-O 40 CFR 63, Subparts Q 40 CFR 63, Subpart T-Y 40 CFR 63, Subparts DD-EE 40 CFR 63, Subpart GG	These requirements are not applicable because the facility is not an affected source as defined in these regulations.
40 CFR 82, Subparts A-E 40 CFR 82, Subparts G-H	These requirements are not applicable because the facility is not an affected source as defined in these regulations.
40 CFR 72 through 40 CFR 78.	These requirements are not applicable because the facility is not an affected source as defined by the acid rain regulations.

B. Emission Units

The permit application identified applicable requirements; non-applicable requirements for individual or specific emissions units were not listed. The Department has listed all non-applicable requirements in Section IV.A. These requirements relate to each specific unit as well as facility wide.

SECTION V. GENERAL PERMIT CONDITIONS

A. Compliance Requirements

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(a)-(c)&(e), §1206(6)(c)&(b)

1. The permittee must comply with all conditions of the permit. Any noncompliance with the terms or conditions of the permit constitutes a violation of the Montana Clean Air Act, and may result in enforcement action, permit modification, revocation and reissuance, or termination, or denial of a permit renewal application under ARM Title 17, Chapter 8, Subchapter 12.

2. The filing of a request by the permittee for a permit modification, revocation and reissuance, or termination, or of a notification of planned changes or anticipated noncompliance does not stay any permit condition.

3. It shall not be a defense for a permittee in an enforcement action that it would have been necessary to halt or reduce the permitted activity in order to maintain compliance with the conditions of the permit. If appropriate, this factor may be considered as a mitigating factor in assessing a penalty for noncompliance with an applicable requirement if the source demonstrates that both the health, safety or environmental impacts of halting or reducing operations would be more serious than the impacts of continuing operations, and that such health, safety or environmental impacts were unforeseeable and could not have otherwise been avoided.

4. The permittee shall furnish to the Department, within a reasonable time set by the Department (not to be less than 15 days), any information that the Department may request in writing to determine whether cause exists for modifying, revoking and reissuing, or terminating the permit, or to determine compliance with the permit. Upon request, the permittee shall also furnish to the Department copies of those records that are required to be kept pursuant to the terms of the permit. This subsection does not impair or otherwise limit the right of the permittee to assert the confidentiality of the information requested by the Department, as provided in 75-2-105, MCA.

5. Any schedule of compliance for applicable requirements with which the source is not in compliance with at the time of permit issuance shall be supplemental to, and shall not sanction noncompliance with, the applicable requirements on which it was based.

6. For applicable requirements that will become effective during the permit term, the source shall meet such requirements on a timely basis unless a more detailed plan or schedule is required by the applicable requirement or the Department.

B. Certification Requirements

ARM 17.8, Subchapter 12, Operating Permit Program §1207 and §1213(7)(a)&(c)-(d)

1. Any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12, shall contain certification by a responsible official of truth, accuracy and completeness. This certification and any other certification required under ARM Title 17, Chapter 8, Subchapter 12, shall state that, based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete.

2. Compliance certifications shall be submitted by January 31 of each year, or more frequently if otherwise specified in an applicable requirement or elsewhere in the permit. Each certification must include the required information for the previous calendar year (i.e., January 1 – December 31).

3. Compliance certifications shall include the following:

   a. The identification of each term or condition of the permit that is the basis of the certification;

   b. The identification of the method(s) or other means used by the owner or operator for determining the status of compliance with each term and condition during the certification period, consistent with ARM 17.8.1212;

   c. The status of compliance with each term and condition for the period covered by the certification, *including whether compliance during the period was continuous or intermittent* (based on the method or means identified in ARM 17.8.1213(7)(c)(ii), as described above); and

   d. Such other facts as the Department may require to determine the compliance status of the source.

4. All compliance certifications must be submitted to the Environmental Protection Agency, as well as to the Department, at the addresses listed in the Notification Addresses Appendix of this permit.

C. Permit Shield

ARM 17.8, Subchapter 12, Operating Permit Program §1214(1)-(4)

1. The applicable requirements and non-federally enforceable requirements are included and specifically identified in this permit and the permit includes a precise summary of the requirements not applicable to the source. Compliance with the conditions of the permit shall be deemed compliance with any applicable requirements and any non-federally enforceable requirements as of the date of permit issuance.

2. The permit shield described in 1 above shall remain in effect during the appeal of any permit action (renewal, revision, reopening, or revocation and reissuance) to the Board of Environmental Review (Board), until such time as the Board renders its final decision.

3. Nothing in this permit alters or affects the following:

   a. The provisions of Sec. 7603 of the FCAA, including the authority of the administrator under that section;

   b. The liability of an owner or operator of a source for any violation of applicable requirements prior to or at the time of permit issuance;

   c. The applicable requirements of the Acid Rain Program, consistent with Sec. 7651g(a) of the FCAA;

   d. The ability of the administrator to obtain information from a source pursuant to Sec. 7414 of the FCAA;

   e. The ability of the Department to obtain information from a source pursuant to the Montana Clean Air Act, Title 75, Chapter 2, MCA;

   f. The emergency powers of the Department under the Montana Clean Air Act, Title 75, Chapter 2, MCA; and

g. The ability of the Department to establish or revise requirements for the use of Reasonably Available Control Technology (RACT) as defined in ARM Title 17, Chapter 8. However, if the inclusion of a RACT into the permit pursuant to ARM Title 17, Chapter 8, Subchapter 12, is appealed to the Board, the permit shield, as it applies to the source's existing permit, shall remain in effect until such time as the Board has rendered its final decision.

4. Nothing in this permit alters or affects the ability of the Department to take enforcement action for a violation of an applicable requirement or permit term demonstrated pursuant to ARM 17.8.106, Source Testing Protocol.

5. Pursuant to ARM 17.8.132, for the purpose of submitting a compliance certification, nothing in these rules shall preclude the use, including the exclusive use, of any credible evidence or information relevant to whether a source would have been in compliance. However, when compliance or noncompliance is demonstrated by a test or procedure provided by permit or other applicable requirements, the source shall then be presumed to be in compliance or noncompliance unless that presumption is overcome by other relevant credible evidence.

6. The permit shield will not extend to minor permit modifications or changes not requiring a permit revision (see Sections I & J).

7. The permit shield will extend to significant permit modifications and transfer or assignment of ownership (see Sections K & N).

D. Monitoring, Recordkeeping, and Reporting Requirements
ARM 17.8, Subchapter 12, operating Permit Program §1212(2)&(3)

1. Unless otherwise provided in this permit, the permittee shall maintain compliance monitoring records that include the following information:

   a. The date, place as defined in the permit, and time of sampling or measurement;

   b. The date(s) analyses were performed;

   c. The company or entity that performed the analyses;

   d. The analytical techniques or methods used;

   e. The results of such analyses; and

   f. The operating conditions at the time of sampling or measurement.

2. The permittee shall retain records of all required monitoring data and support information for a period of at least 5 years from the date of the monitoring sample, measurement, report, or application. Support information includes all calibration and maintenance records and all original strip-chart recordings for continuous monitoring instrumentation, and copies of all reports required by the permit. All monitoring data, support information, and required reports and summaries may be maintained in computerized form at the plant site if the information is made available to Department personnel upon request, which may be for either hard copies or computerized format. Strip-charts must be maintained in their original form at the plant site and shall be made available to Department personnel upon request.

3. The permittee shall submit to the Department, at the addresses located in the Notification Addresses Appendix of this permit, reports of any required monitoring by January 31 and July 31 of each year, or more frequently if otherwise specified in an applicable requirement or elsewhere in the permit. The monitoring report submitted on January 31 of each year must include the required monitoring information for the period of July 1 through December 31 of the previous year. The monitoring report submitted on July 31 of each year must include the required monitoring information for the period of January 1 through June 30 of the current year. All instances of deviations from the permit requirements must be clearly identified in such reports. All required reports must be certified by a responsible official, consistent with ARM 17.8.1207.

E. Prompt Deviation Reporting

ARM 17.8, Subchapter 12, Operating Permit Program §1212(3)(c)

The permittee shall promptly report deviations from permit requirements, including those attributable to upset conditions as defined in the permit, the probable cause of such deviations, and any corrective actions or preventive measures taken. To be considered prompt, deviations shall be reported as part of the routine reporting requirements under ARM 17.8.1212(3)(b) and, if applicable, in accordance with the malfunction reporting requirements under ARM 17.8.110, unless otherwise specified in an applicable requirement.

F. Emergency Provisions

ARM 17.8, Subchapter 12, Operating Permit Program §1201(13) and §1214(5), (6)&(8)

1. An "emergency" means any situation arising from sudden and reasonably unforeseeable events beyond the control of the source, including acts of God, which situation requires immediate corrective action to restore normal operation and causes the source to exceed a technology-based emission limitation under this permit due to the unavoidable increases in emissions attributable to the emergency. An emergency shall not include noncompliance to the extent caused by improperly designed equipment, lack of reasonable preventive maintenance, careless or improper operation, or operator error.

2. An emergency constitutes an affirmative defense to an action brought for noncompliance with a technology-based emission limitation if the permittee demonstrates through properly signed, contemporaneous logs, or other relevant evidence, that:

   a. An emergency occurred and the permittee can identify the cause(s) of the emergency;

   b. The permitted facility was at the time being properly operated;

   c. During the period of the emergency the permittee took all reasonable steps to minimize levels of emissions that exceeded the emission standards or other requirements in the permit; and

   d. The permittee submitted notice of the emergency to the Department within 2 working days of the time when emission limitations were exceeded due to the emergency. This notice fulfills the requirements of ARM 17.8.1212(3)(c). This notice must contain a description of the emergency, any steps taken to mitigate emissions, and corrective actions taken.

3. These emergency provisions are in addition to any emergency, malfunction or upset provision contained in any applicable requirement.

G. Inspection and Entry

ARM 17.8, Subchapter 12, Operating Permit Program §1213(3)&(4)

1. Upon presentation of credentials and other requirements as may be required by law, the permittee shall allow the Department, the administrator, or an authorized representative (including an authorized contractor acting as a representative of the Department or the administrator) to perform the following:

   a. Enter the premises where a source required to obtain a permit is located or emissions-related activity is conducted, or where records must be kept under the conditions of the permit;

   b. Have access to and copy, at reasonable times, any records that must be kept under the conditions of the permit;

   c. Inspect at reasonable times any facilities, emission units, equipment (including monitoring and air pollution control equipment), practices, or operations regulated or required under the permit; and

   d. As authorized by the Montana Clean Air Act and rules promulgated thereunder, sample or monitor, at reasonable times, any substances or parameters at any location for the purpose of assuring compliance with the permit or applicable requirements.

2. The permittee shall inform the inspector of all workplace safety rules or requirements at the time of inspection. This section shall not limit in any manner the Department's statutory right of entry and inspection as provided for in 75-2-403, MCA.

H. Fee Payment

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(f) and ARM 17.8, Subchapter 5, Air Quality Permit Application, Operation, and Open Burning Fees §505(3)-(5) (STATE ONLY)

1. The permittee must pay application and operating fees, pursuant to ARM Title 17, Chapter 8, Subchapter 5.

2. Annually, the Department shall provide the permittee with written notice of the amount of the fee and the basis for the fee assessment. The air quality operation fee is due 30 days after receipt of the notice, unless the fee assessment is appealed pursuant to ARM 17.8.511. If any portion of the fee is not appealed, that portion of the fee that is not appealed is due 30 days after receipt of the notice. Any remaining fee, which may be due after the completion of an appeal, is due immediately upon issuance of the Board's decision or upon completion of any judicial review of the Board's decision.

3. If the permittee fails to pay the required fee (or any required portion of an appealed fee) within 90 days of the due date of the fee, the Department may impose an additional assessment of 15% of the fee (or any required portion of an appealed fee) or $100, whichever is greater, plus interest on the fee (or any required portion of an appealed fee), computed at the interest rate established under 15-31-510(3), MCA.

I. Minor Permit Modifications

ARM 17.8, Subchapter 12, Operating Permit Program §1226(3)&(11)

1. An application for a minor permit modification need only address in detail those portions of the permit application that require revision, updating, supplementation, or deletion, and may reference any required information that has been previously submitted.

2. The permit shield under ARM 17.8.1214 will not extend to any minor modifications processed pursuant to ARM 17.8.1226.

J. Changes Not Requiring Permit Revision
ARM 17.8, Subchapter 12, Operating Permit Program §1224(1)-(3), (5)&(6)

1. The permittee is authorized to make changes within the facility as described below, provided the following conditions are met.

   a. The proposed changes do not require the permittee to obtain an air quality preconstruction permit under ARM Title 17, Chapter 8, Subchapter 7;

   b. The proposed changes are not modifications under Title I of the FCAA, or as defined in ARM Title 17, Chapter 8, Subchapters 8, 9, or 10;

   c. The emissions resulting from the proposed changes do not exceed the emissions allowable under this permit, whether expressed as a rate of emissions or in total emissions;

   d. The proposed changes do not alter permit terms that are necessary to enforce applicable emission limitations on emission units covered by the permit; and

   e. The facility provides the administrator and the Department with written notification at least 7 days prior to making the proposed changes.

2. The permittee and the Department shall attach each notice provided pursuant to 1.e above to their respective copies of this permit.

3. Pursuant to the conditions above, the permittee is authorized to make Section 502(b)(10) changes, as defined in ARM 17.8.1201(30), without a permit revision. For each such change, the written notification required under 1.e above shall include a description of the change within the source, the date on which the change will occur, any change in emissions, and any permit term or condition that is no longer applicable as a result of the change.

4. The permittee may make a change not specifically addressed or prohibited by the permit terms and conditions without requiring a permit revision, provided the following conditions are met.

   a. Each proposed change does not weaken the enforceability of any existing permit conditions;

   b. The Department has not objected to such change;

   c. Each proposed change meets all applicable requirements and does not violate any existing permit term or condition; and

   d. The permittee provides contemporaneous written notice to the Department and the administrator of each change that is above the level for insignificant emission units as defined in ARM 17.8.1201(22) and 17.8.1206(3), and the written notice describes each such change, including the date of the change, any change in emissions, pollutants emitted, and any applicable requirement that would apply as a result of the change.

5. The permit shield authorized by ARM 17.8.1214 shall not apply to changes made pursuant to ARM 17.8.1224(3) and (5), but is applicable to terms and conditions that allow for increases and decreases in emissions pursuant to ARM 17.8.1224(4).

K. Significant Permit Modifications
ARM 17.8, Subchapter 12, Operating Permit Program §1227(1), (3)&(4)

1. The modification procedures set forth in 2 below must be used for any application requesting a significant modification of this permit. Significant modifications include the following:

   a. Any permit modification that does not qualify as either a minor modification or as an administrative permit amendment;

   b. Every significant change in existing permit monitoring terms or conditions;

   c. Every relaxation of permit reporting or recordkeeping terms or conditions that limit the Department's ability to determine compliance with any applicable rule, consistent with the requirements of the rule; or

   d. Any other change determined by the Department to be significant.

2. Significant modifications shall meet all requirements of ARM Title 17, Chapter 8, including those for applications, public participation, and review by affected states and the administrator, as they apply to permit issuance and renewal, except that an application for a significant permit modification need only address in detail those portions of the permit application that require revision, updating, supplementation or deletion.

3. The permit shield provided for in ARM 17.8.1214 shall extend to significant modifications.

L. Reopening for Cause
ARM 17.8, Subchapter 12, Operating Permit Program §1228(1)&(2)

1. This permit may be reopened and revised under the following circumstances:

   a. Additional applicable requirements under the FCAA become applicable to the facility when the permit has a remaining term of 3 or more years. Reopening and revision of the permit shall be completed not later than 18 months after promulgation of the applicable requirement. No reopening is required under ARM 17.8.1228(1)(a) if the effective date of the applicable requirement is later than the date on which the permit is due to expire, unless the original permit or any of its terms or conditions have been extended pursuant to ARM 17.8.1220(12) or 17.8.1221(2);

   b. Additional requirements (including excess emission requirements) become applicable to an affected source under the Acid Rain Program. Upon approval by the administrator, excess emission offset plans shall be deemed incorporated into the permit;

   c. The Department or the administrator determines that the permit contains a material mistake or that inaccurate statements were made in establishing the emission standards or other terms or conditions of the permit; or

   d. The administrator or the Department determines that the permit must be revised or revoked and reissued to ensure compliance with the applicable requirements.

M. Permit Expiration and Renewal
ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(g), §1220(11)&(12), and §1205(2)(d)

1. This permit is issued for a fixed term of 5 years.

2. Renewal of this permit is subject to the same procedural requirements that apply to permit issuance, including those for application, content, public participation, and affected state and administrator review.

3. Expiration of this permit terminates the permittee's right to operate unless a timely and administratively complete renewal application has been submitted consistent with ARM 17.8.1221 and 17.8.1205(2)(d). If a timely and administratively complete application has been submitted, all terms and conditions of the permit, including the application shield, remain in effect after the permit expires until the permit renewal has been issued or denied.

4. For renewal, the permittee shall submit a complete air quality operating permit application to the Department not later than 6 months prior to the expiration of this permit, unless otherwise specified. If necessary to ensure that the terms of the existing permit will not lapse before renewal, the Department may specify, in writing to the permittee, a longer time period for submission of the renewal application. Such written notification must be provided at least 1 year before the renewal application due date established in the existing permit.

N. Severability Clause
ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(i)&(l)

1. The administrative appeal or subsequent judicial review of the issuance by the Department of an initial permit under this subchapter shall not impair in any manner the underlying applicability of all applicable requirements, and such requirements continue to apply as if a final permit decision had not been reached by the Department.

2. If any provision of a permit is found to be invalid, all valid parts that are severable from the invalid part remain in effect. If a provision of a permit is invalid in one or more of its applications, the provision remains in effect in all valid applications that are severable from the invalid applications.

O. Transfer or Assignment of Ownership
ARM 17.8, Subchapter 12, Operating Permit Program §1225(2)&(4)

1. If an administrative permit amendment involves a change in ownership or operational control, the applicant must include in its request to the Department a written agreement containing a specific date for the transfer of permit responsibility, coverage and liability between the current and new permittee.

2. The permit shield provided for in ARM17.8.1214 shall not extend to administrative permit amendments.

P. Emissions Trading, Marketable Permits, Economic Incentives
ARM 17.8, Subchapter 12, Operating Permit Program §1226(2)

Notwithstanding ARM 17.8.1226(1) and (7), minor air quality operating permit modification procedures may be used for permit modifications involving the use of economic incentives, marketable permits, emissions trading, and other similar approaches, to the extent that such minor permit modification procedures are explicitly provided for in the Montana State Implementation Plan or in applicable requirements promulgated by the administrator.

Q. No Property Rights Conveyed
ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(d)

This permit does not convey any property rights of any sort, or any exclusive privilege.

R. Testing Requirements
ARM 17.8, Subchapter 1, General Provisions §105

The permittee shall comply with ARM 17.8.105.

S. Source Testing Protocol
ARM 17.8, Subchapter 1, General Provisions §106

The permittee shall comply with ARM 17.8.106.

T. Malfunctions
ARM 17.8, Subchapter 1, General Provisions §110

The permittee shall comply with ARM 17.8.110.

U. Circumvention
ARM 17.8, Subchapter 1, General Provisions §111

The permittee shall comply with ARM 17.8.111.

V. Motor Vehicles
ARM 17.8, Subchapter 3, Emission Standards §325

The permittee shall comply with ARM 17.8.325.

W. Annual Emissions Inventory
ARM 17.8, Subchapter 5, Air Quality Permit Application, Operation and Open Burning Fees §505 (STATE ONLY)

The permittee shall supply the Department with annual production and other information for all emission units necessary to calculate actual or estimated actual amount of air pollutants emitted during each calendar year. Information shall be gathered on a calendar-year basis and submitted to the Department by the date required in the emission inventory request, unless otherwise specified in this permit. Information shall be in the units required by the Department.

X. Open Burning
ARM 17.8, Subchapter 6, Open Burning §604, 605 and 606

The permittee shall comply with ARM 17.8.604, 605 and 606.

Y. Preconstruction Permits
ARM 17.8, Subchapter 7, Permit, Construction and Operation of Air Contaminant Sources §745 and 764 (ARM 17.8.745(1) and 764(1)(b) are STATE ENFORCEABLE ONLY until approval by the EPA as part of the SIP)

1. Except as specified, no person shall construct, install, alter or use any air contaminant source or stack associated with any source without first obtaining a permit from the Department or Board. A permit is not required for those sources or stacks as specified by ARM 17.8.744(1)(a)-(k).

2. The permittee shall comply with ARM 17.8.743, 744, 745, 748, and 764.

3. ARM 17.8.745(1) specifies de minimis changes as construction or changed conditions of operation at a facility holding an air quality preconstruction permit issued under Chapter 8 that does not increase the facility's potential to emit by more than 15 tons per year of any pollutant, except (STATE ENFORCEABLE ONLY until approved by the EPA as part of the SIP):

   a. Any construction or changed condition that would violate any condition in the facility's existing air quality preconstruction permit or any applicable rule contained in Chapter 8 is prohibited, except as provided in ARM 17.8.745(2);

   b. Any construction or changed conditions of operation that would qualify as a major modification under Subchapters 8, 9 or 10 of Chapter 8;

   c. Any construction or changed condition of operation that would affect the plume rise or dispersion characteristic of emissions that would cause or contribute to a violation of an ambient air quality standard or ambient air increment as defined in ARM 17.8.804;

   d. Any construction or improvement project with a potential to emit more than 15 tons per year may not be artificially split into smaller projects to avoid air quality preconstruction permitting; or

   e. Emission reductions obtained through offsetting within a facility are not included when determining the potential emission increase from construction or changed conditions of operation, unless such reductions are made federally enforceable.

4. Any facility making a de minimis change pursuant to ARM 17.8.745(1) shall notify the Department if the change would include a change in control equipment, stack height, stack diameter, stack gas temperature, source location or fuel specifications, or would result in an increase in source capacity above its permitted operation or the addition of a new emission unit. The notice must be submitted, in writing, 10 days prior to start up or use of the proposed de minimis change, or as soon as reasonably practicable in the event of an unanticipated circumstance causing the de minimis change, and must include the information requested in ARM 17.8.745(1). (STATE ENFORCEABLE ONLY until approval by the EPA as part of the SIP)

Z. National Emission Standard for Asbestos
40 CFR, Part 61, Subpart M

The permittee shall not conduct any asbestos abatement activities except in accordance with 40 CFR 61, Subpart M (National Emission Standard for Hazardous Air Pollutants for Asbestos).

AA. Asbestos
ARM 17.74, Subchapter 3, General Provisions and Subchapter 4, Fees

The permittee shall comply with ARM 17.74.301, *et seq*., and ARM 17.74.401, *et seq*. (State only)

BB. Stratospheric Ozone Protection – Servicing of Motor Vehicle Air Conditioners
40 CFR, Part 82, Subpart B

If the permittee performs a service on motor vehicles and this service involves ozone-depleting substance/refrigerant in the motor vehicle air conditioner (MVAC), the permittee is subject to all the applicable requirements as specified in 40 CFR 82, Subpart B.

CC. Stratospheric Ozone Protection – Recycling and Emission Reductions

40 CFR, Part 82, Subpart F

The permittee shall comply with the standards for recycling and emission reductions in 40 CFR 82, Subpart F, except as provided for MVACs in Subpart B.

1. Persons opening appliances for maintenance, service, repair, or disposal must comply with the required practices pursuant to §82.156.

2. Equipment used during the maintenance, service, repair or disposal of appliances must comply with the standards for recycling and recovery equipment pursuant to §82.158.

3. Persons performing maintenance, service, repair or disposal of appliances must be certified by an approved technical certification program pursuant to §82.161.

4. Persons disposing of small appliances, MVACs and MVAC-like (as defined at §82.152) appliances must comply with recordkeeping requirements pursuant to §82.166.

5. Persons owning commercial or industrial process refrigeration equipment must comply with the leak repair requirements pursuant to §82.156.

6. Owners/operators of appliances normally containing 50 or more pounds of refrigerant must keep records of refrigerant purchased and added to such appliances pursuant to §82.166.

DD. Emergency Episode Plan

The permittee shall comply with the requirements contained in Chapter 9.7 of the State of Montana Air Quality Control Implementation Plan.

Each major source emitting 100 tons per year located in a Priority I Air Quality Control Region, shall submit to the Department a legally enforceable Emergency Episode Action Plan (EEAP) that details how the source will curtail emissions during an air pollutant emergency episode. The industrial EEAP shall be in accordance with the Department's EEAP and shall be submitted according to a timetable developed by the Department, following Priority I reclassification.

EE. Definitions

Terms not otherwise defined in this permit or in the Definitions and Abbreviations Appendix of this permit, shall have the meaning assigned to them in the referenced regulations.

APPENDICES

APPENDIX A INSIGNIFICANT EMISSION UNITS

Disclaimer: The information in this appendix is not State or Federally enforceable, but is presented to assist ConocoPhillips, the permitting authority, inspectors, and the public.

Pursuant to ARM 17.8.1201(22)(a), an insignificant emission unit means any activity or emission unit located within a source that: (i) has a potential to emit less than 5 tons per year of any regulated pollutant; (ii) has a potential to emit less than 500 pounds per year of lead; (iii) has a potential to emit less than 500 pounds per year of hazardous air pollutants listed pursuant to Sec. 7412 (b) of the FCAA; and (iv) is not regulated by an applicable requirement, other than a generally applicable requirement that applies to all emission units subject to Subchapter 12.

List of Insignificant Activities:

ConocoPhillips provided an update to the 6/12/96 application on 5/3/00 in which all references to insignificant sources were either moved to significant units or deleted from the previous list.

APPENDIX B DEFINITIONS and ABBREVIATIONS

"Act" means the Clean Air Act, as amended, 42 U.S. 7401, *et seq*.

"Administrative permit amendment" means an air quality operating permit revision that:

(a) Corrects typographical errors;

(b) Identifies a change in the name, address or phone number of any person identified in the air quality operating permit, or identifies a similar minor administrative change at the source;

(c) Requires more frequent monitoring or reporting by ConocoPhillips;

(d) Requires changes in monitoring or reporting requirements that the Department deems to be no less stringent than current monitoring or reporting requirements;

(e) Allows for a change in ownership or operational control of a source if the Department has determined that no other change in the air quality operating permit is necessary, consistent with ARM 17.8.1225; or

(f) Incorporates any other type of change, which the Department has determined to be similar to those revisions set forth in (a)-(e), above.

"Applicable requirement" means all of the following as they apply to emission units in a source requiring an air quality operating permit (including requirements that have been promulgated or approved by the Department or the administrator through rule making at the time of issuance of the air quality operating permit, but have future-effective compliance dates, provided that such requirements apply to sources covered under the operating permit):

(a) Any standard, rule, or other requirement, including any requirement contained in a consent decree or judicial or administrative order entered into or issued by the Department, that is contained in the Montana state implementation plan approved or promulgated by the administrator through rule making under Title I of the FCAA;

(b) Any federally enforceable term, condition or other requirement of any Montana Air Quality permit issued by the Department under subchapters 7, 8, 9 and 10 of this chapter, or pursuant to regulations approved or promulgated through rule making under Title I of the FCAA, including parts C and D;

(c) Any standard or other requirement under Sec. 7411 of the FCAA, including Sec. 7411(d);

(d) Any standard or other requirement under Sec. 7412 of the FCAA, including any requirement concerning accident prevention under Sec. 7412(r)(7), but excluding the contents of any risk management plan required under Sec. 7412(r);

(e) Any standard or other requirement of the acid rain program under Title IV of the FCAA or regulations promulgated thereunder;

(f) Any requirements established pursuant to Sec. 7661c(b) or Sec. 7414(a)(3) of the FCAA;

(g) Any standard or other requirement governing solid waste incineration, under Sec. 7429 of the FCAA;

(h) Any standard or other requirement for consumer and commercial products, under Sec. 7511b(e) of the FCAA;

(i) Any standard or other requirement for tank vessels, under Sec. 7511b(f) of the FCAA;

(j) Any standard or other requirement of the regulations promulgated to protect stratospheric ozone under Title VI of the FCAA, unless the administrator determines that such requirements need not be contained in an air quality operating permit;

(k) Any national ambient air quality standard or increment or visibility requirement under part C of Title I of the FCAA, but only as it would apply to temporary sources permitted pursuant to Sec. 7661c(e) of the FCAA; or

(l) Any federally enforceable term or condition of any air quality open burning permit issued by the Department under subchapter 6.

"Department" means the Montana Department of Environmental Quality.

"Emission unit" means any part or activity of a stationary source that emits or has the potential to emit any regulated air pollutant or any pollutant listed under Sec. 7412(b) of the FCAA. This term is not meant to alter or affect the definition of the term "unit" for purposes of Title IV of the FCAA.

"FCAA" means the Federal Clean Air Act, as amended.

"Federally enforceable" means all limitations and conditions which are enforceable by the administrator, including those requirements developed pursuant to 40 CFR Parts 60 and 61, requirements within the Montana state implementation plan, and any permit requirement established pursuant to 40 CFR 52.21 or under regulations approved pursuant to 40 CFR Part 51, Subpart I, including operating permits issued under an EPA approved program that is incorporated into the Montana state implementation plan and expressly requires adherence to any permit issued under such program.

"Fugitive emissions" means those emissions that could not reasonably pass through a stack, chimney, vent, or other functionally equivalent opening.

"General air quality operating permit" or **"general permit"** means an air quality operating permit that meets the requirements of ARM 17.8.1222, covers multiple sources in a source category, and is issued in lieu of individual permits being issued to each source.

"Hazardous air pollutant" means any air pollutant listed as a hazardous air pollutant pursuant to Sec. 112(b) of the FCAA.

"Non-federally enforceable requirement" means the following as they apply to emission units in a source requiring an air quality operating permit:

(a) Any standard, rule, or other requirement, including any requirement contained in a consent decree, or judicial or administrative order entered into or issued by the Department, that is not contained in the Montana state implementation plan approved or promulgated by the administrator through rule making under Title I of the FCAA;

(b) Any term, condition or other requirement contained in any Montana Air Quality permit issued by the Department under subchapters 7, 8, 9 and 10 of this chapter that is not federally enforceable;

(c) Does not include any Montana ambient air quality standard contained in Subchapter 2 of this chapter.

"Permittee" means the owner or operator of any source subject to the permitting requirements of this subchapter, as provided in ARM 17.8.1204, that holds a valid air quality operating permit or has submitted a timely and complete permit application for issuance, renewal, amendment, or modification pursuant to this subchapter.

"Regulated air pollutan" means the following:

(a) Nitrogen oxides or any volatile organic compounds;

(b) Any pollutant for which a national ambient air quality standard has been promulgated;

(c) Any pollutant that is subject to any standard promulgated under Sec. 7411 of the FCAA;

(d) Any Class I or II substance subject to a standard promulgated under or established by Title VI of the FCAA; or

(e) Any pollutant subject to a standard or other requirement established or promulgated under Sec. 7412 of the FCAA, including but not limited to the following:

(i) Any pollutant subject to requirements under Sec. 7412(j) of the FCAA. If the administrator fails to promulgate a standard by the date established in Sec. 7412(e) of the FCAA, any pollutant for which a subject source would be major shall be considered to be regulated on the date 18 months after the applicable date established in Sec. 7412(e) of the FCAA;

(ii) Any pollutant for which the requirements of Sec. 7412(g)(2) of the FCAA have been met but only with respect to the individual source subject to Sec. 7412(g)(2) requirement.

"Responsible official" means one of the following:

(a) For a corporation: a president, secretary, treasurer, or vice-president of the corporation in charge of a principal business function, or any other person who performs similar policy or decision-making functions for the corporation, or a duly authorized representative of such person if the representative is responsible for the overall operation of one or more manufacturing, production, or operating facilities applying for or subject to a permit and either:

(i) The facilities employ more than 250 persons or have gross annual sales or expenditures exceeding $25 million (in second quarter 1980 dollars); or

(ii) The delegation of authority to such representative is approved in advance by the Department.

(b) For a partnership or sole proprietorship: a general partner or the proprietor, respectively.

(c) For a municipality, state, federal, or other public agency: either a principal executive officer or ranking elected official. For the purposes of this part, a principal executive officer of a federal agency includes the chief executive officer having responsibility for the overall operations of a principal geographic unit of the agency (e.g., a regional administrator of the environmental protection agency).

(d) For affected sources: the designated representative in so far as actions, standards, requirements, or prohibitions under Title IV of the FCAA or the regulations promulgated thereunder are concerned, and the designated representative for any other purposes under this subchapter.

Abbreviations:

ARM	Administrative Rules of Montana
ASTM	American Society of Testing Materials
BACT	Best Available Control Technology
BDT	bone dry tons
Btu	British thermal unit
CEMS	Continuous Emission Monitoring System
COMS	Continuous Opacity Monitoring System
CFR	Code of Federal Regulations
CO	carbon monoxide
DEQ	Department of Environmental Quality
dscf	dry standard cubic foot
dscfm	dry standard cubic foot per minute
EEAP	Emergency Episode Action Plan
EPA	U.S. Environmental Protection Agency
EPA Method	Test methods contained in 40 CFR 60, Appendix A
EU	emission unit
FCAA	Federal Clean Air Act
gr	grains
HAP	hazardous air pollutant
IEU	insignificant emission unit
Mbdft	thousand board feet
Method 5	40 CFR 60, Appendix A, Method 5
Method 9	40 CFR 60, Appendix A, Method 9
MMbdft	million board feet
MMBtu	million British thermal units
NO_x	oxides of nitrogen
NO_2	nitrogen dioxide
O_2	oxygen
Pb	lead
PM	particulate matter
PM_{10}	particulate matter less than 10 microns in size
psi	pounds per square inch
scf	standard cubic feet
SIC	Source Industrial Classification
SO_2	sulfur dioxide
SO_x	oxides of sulfur
tpy	tons per year
U.S.C.	United States Code
VE	visible emissions
VOC	volatile organic compound

APPENDIX C NOTIFICATION ADDRESSES

Compliance Notifications:

Montana Department of Environmental Quality
Permitting and Compliance Division
Air & Waste Management Bureau
P.O. Box 200901
Helena, MT 59620-0901

DEQ - Air and Waste Management Bureau
Airport Industrial Park 1P-9
1371 Rimtop Dr.
Billings MT 59105-1978

U.S. EPA Region VIII, Montana Office
Air Program Coordinator
Federal Office Building
10 West 15th Street, Suite 3200
Helena, MT 59626

Permit Modifications:

Montana Department of Environmental Quality
Permitting and Compliance Division
Air & Waste Management Bureau
P.O. Box 200901
Helena, MT 59620-0901

Office of Partnerships and Regulatory Assistance
Air and Radiation Program
US EPA Region VIII 8P-AR
999 18th Street, Suite 300
Denver, CO 80202-2466

APPENDIX D AIR QUALITY INSPECTOR INFORMATION

Disclaimer: The information in this appendix is not State or Federally enforceable but is presented to assist ConocoPhillips, permitting authority, inspectors, and the public.

1. **Direction to Plant:** 401 South 23rd Street, Billings Montana, 59103

2. **Safety Equipment Required:** ConocoPhillips has an extensive safety orientation package that inspectors and/or visitors must participate in.

   A safety video must be watched. Electronic Temporary Identification Cards are issued. Safety equipment such as tyvex coats, safety glass, ear plugs, H_2S monitors are all available for visitors. Steel-toed boots should be worn while on site.

3. **Facility Plot Plan:** A facility plot plan was submitted with the original application on June 12, 1996.